

FIG. 1

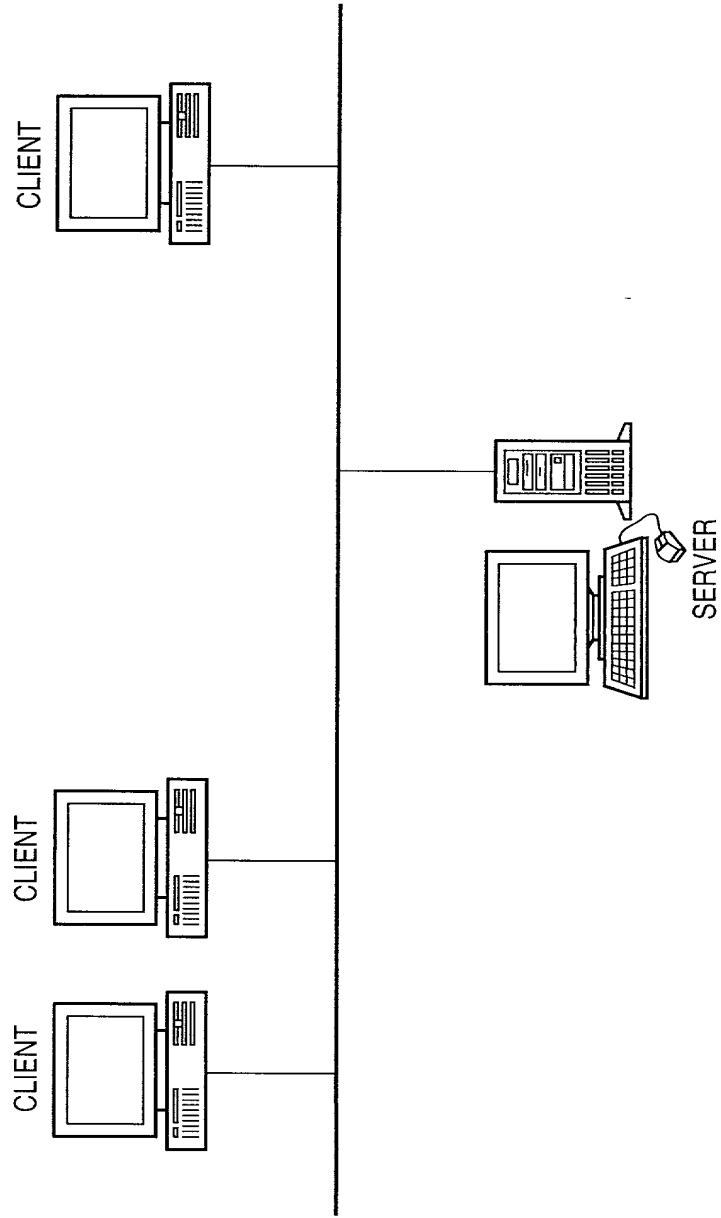


FIG. 2

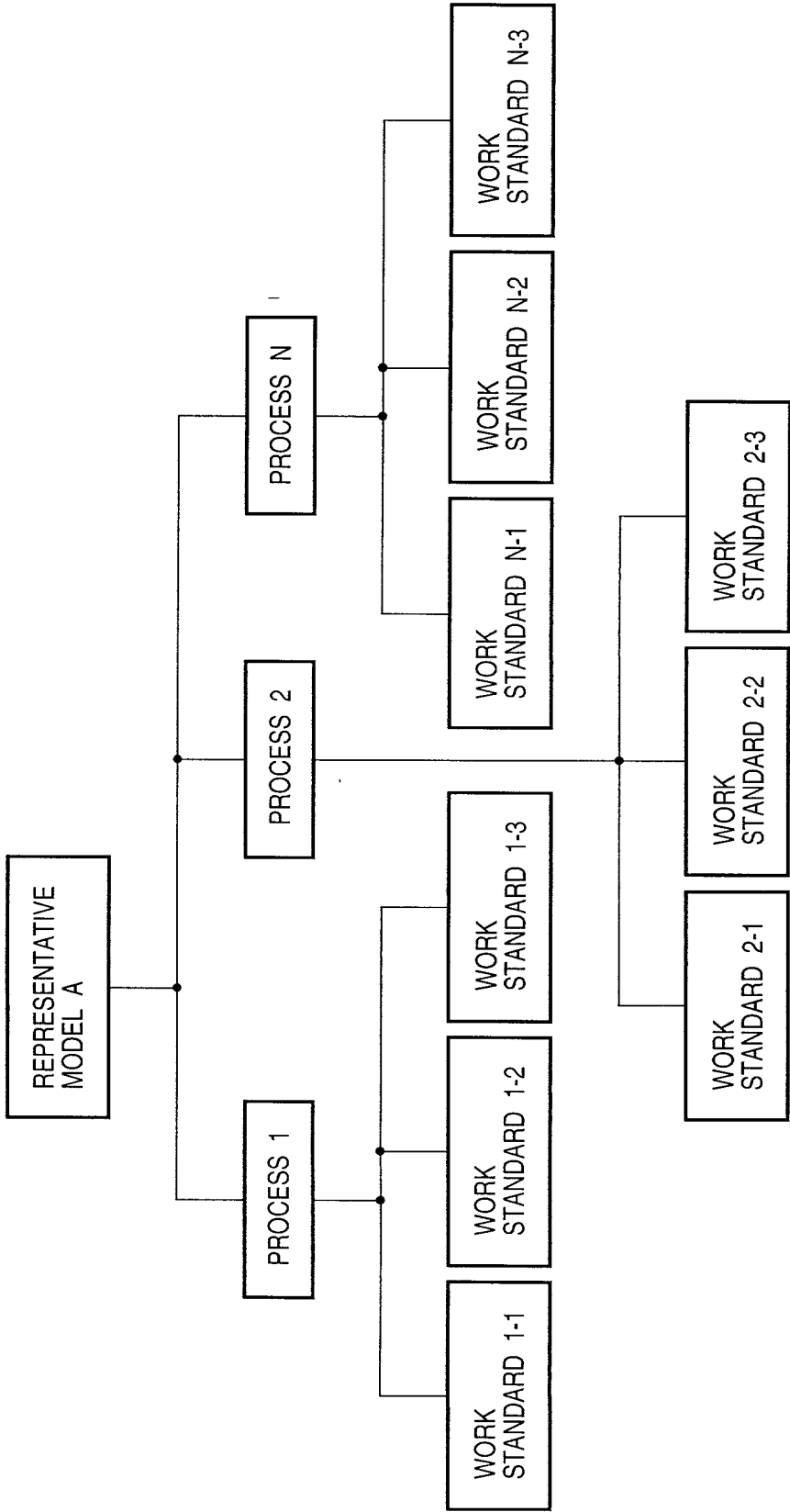


FIG. 3

WORK STANDARD 01 CREATION										300																														
APPLIED										301																														
<table border="1"> <thead> <tr> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> </tr> </thead> <tbody> <tr> <td>303</td> <td>304</td> <td>305</td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>										PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY	303	304	305																302						
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY																																			
303	304	305																																						
<table border="1"> <thead> <tr> <th colspan="3">TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL</th> <th>QUANTITY</th> <th>CHECK ETC.</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td></td> <td>306</td> <td>307</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td>308</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>										TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL			QUANTITY	CHECK ETC.				306	307					308						303										
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL			QUANTITY	CHECK ETC.																																				
			306	307																																				
				308																																				
<table border="1"> <thead> <tr> <th>No.</th> <th>WORK PROCEDURE</th> <th>No.</th> <th>NOTE / STANDARD ETC.</th> </tr> </thead> <tbody> <tr> <td></td> <td>310</td> <td></td> <td></td> </tr> </tbody> </table>										No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.		310			309																						
No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.																																					
	310																																							
<table border="1"> <thead> <tr> <th>REVISION NUMBER</th> <th>CONTENTS OF REVISION</th> <th>DATE</th> <th>PERSON IN CHARGE</th> <th>APPROVE</th> <th>WORK NAME</th> </tr> </thead> <tbody> <tr> <td>01</td> <td>CREATED</td> <td>1997/09/25</td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td>MANAGEMENT NO.</td> </tr> </tbody> </table>										REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME	01	CREATED	1997/09/25																					MANAGEMENT NO.	311
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME																																			
01	CREATED	1997/09/25																																						
					MANAGEMENT NO.																																			
										312																														

FIG. 4

STRUCTURE OF MASTER FILE

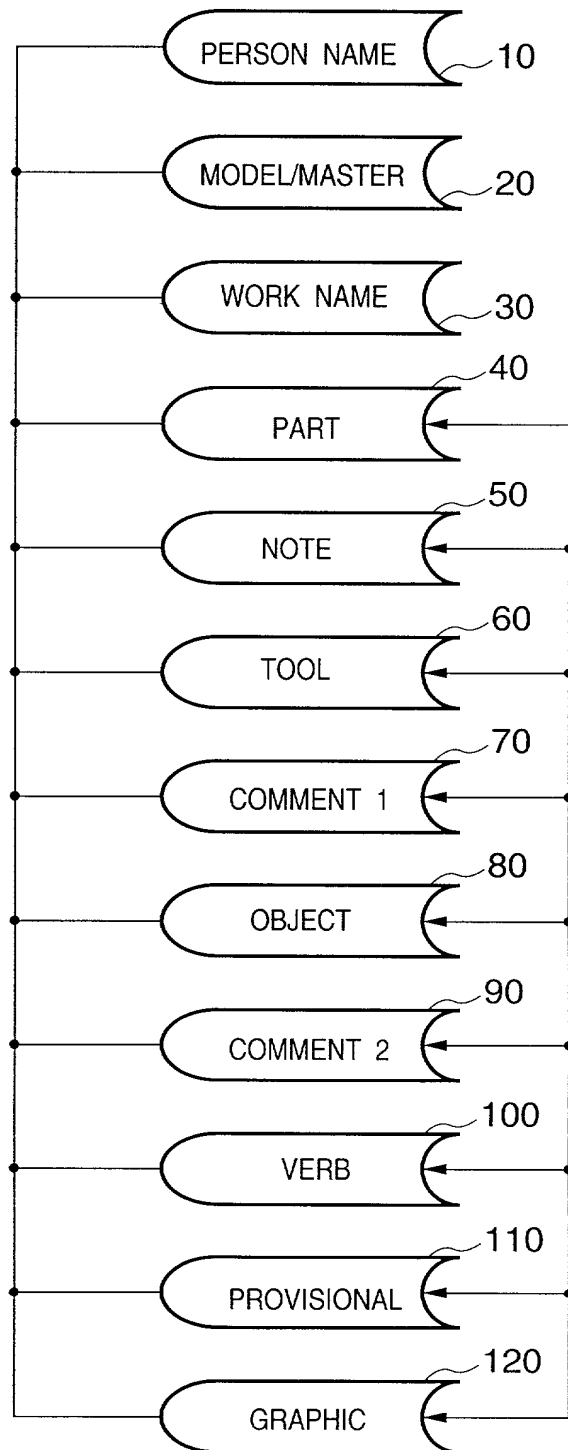


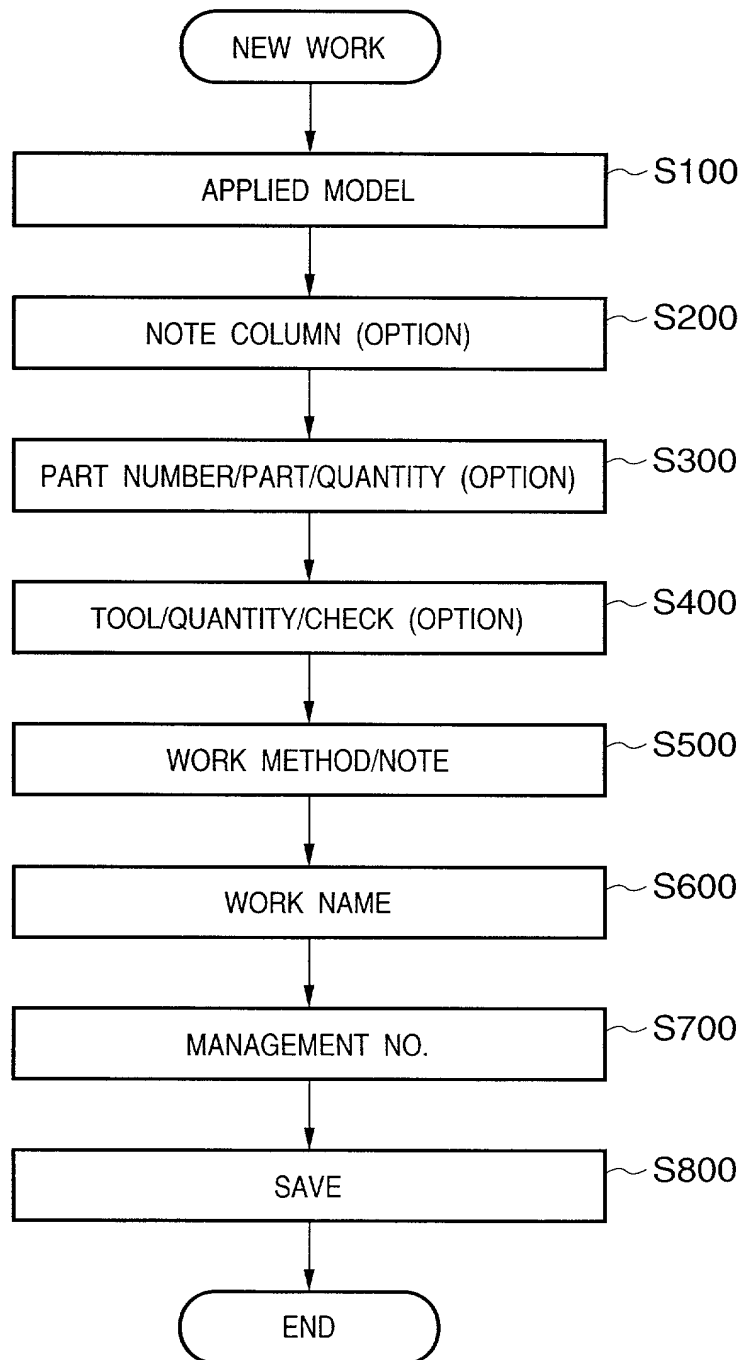
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX
A250 II Q
BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION					<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J									
PART NUMBER		PART NAME		QUANTITY		PART NUMBER		PART NAME		QUANTITY	

302

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

• WORK NAME

GE ____

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

• WORK NAME

現像(GENZOU) __

• CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※ 1105a

01 1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK 1108 CANCEL

11/97

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13

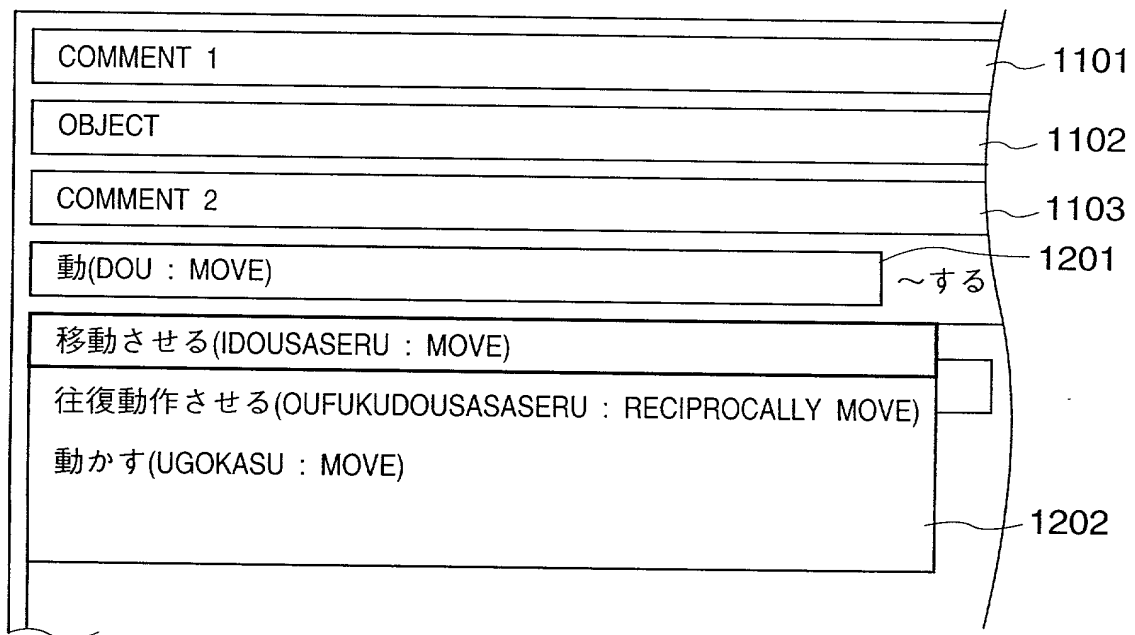


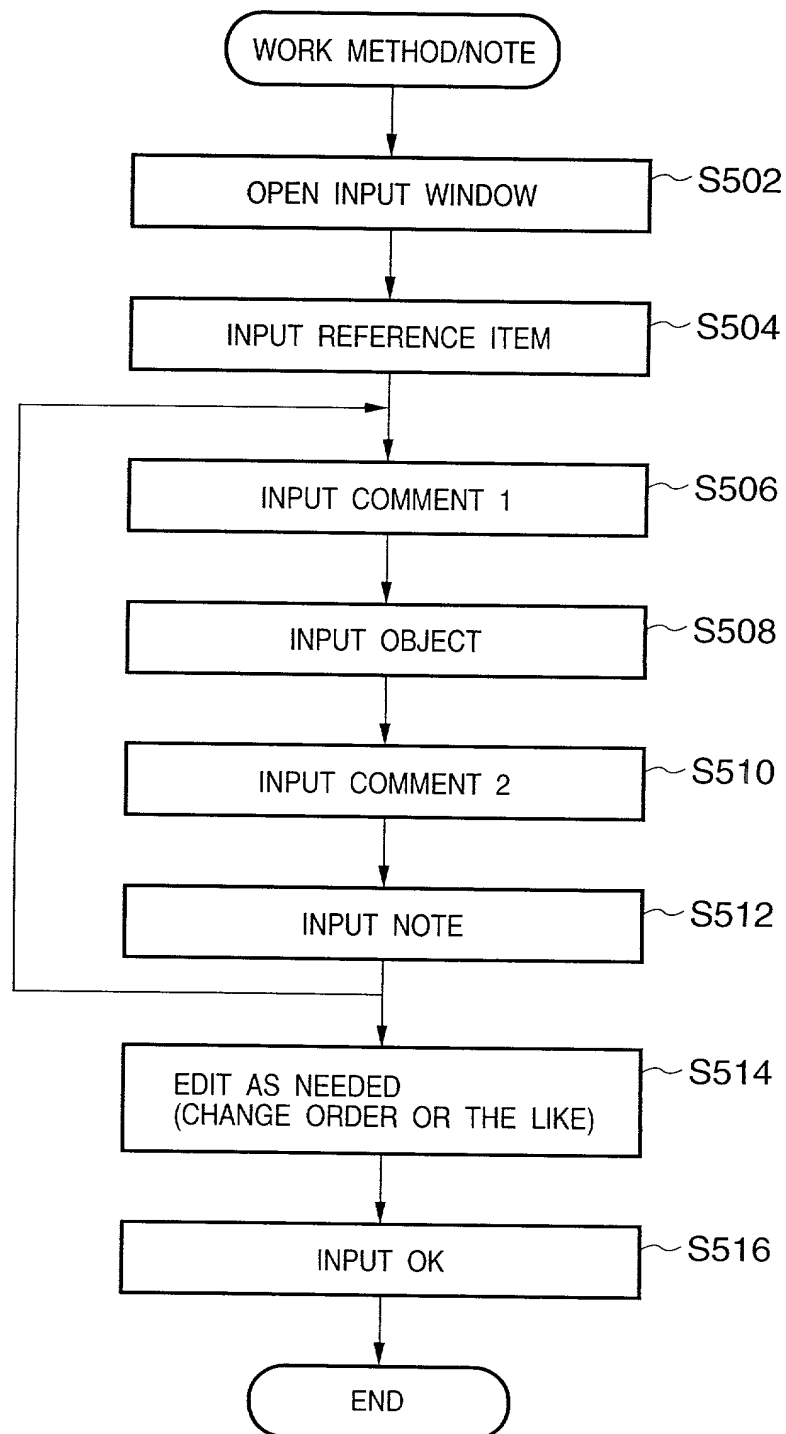
FIG. 14

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	1601
NOTE	
<p>SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu</p> <p>DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE</p> <p>DON'T HOOK PAPER GUIDE u ON SHEET HOLDER</p> <p>BEWARE OF IMITATIONS</p> <p>BEWARE OF IMITATIONS(Color Style Write</p>	1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	CUT(I)
02 WIND AV CORD	COPY(C)
03 SET CRG HOLDER	PASTE(P)
04	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 19

CONFIRM		～する
00	※	
01	WIND AV CORD	
02	CONFIRM 100V SYSTEM	
03	SET CRG HOLDER	
04		

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div>CUT(I) COPY(C) PASTE(P) ADD(A) DELETE(D) UNDO REVISE(CHANGE) REVISE(DELETE)</div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	✂ 📄 🖨 ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

FIG. 22

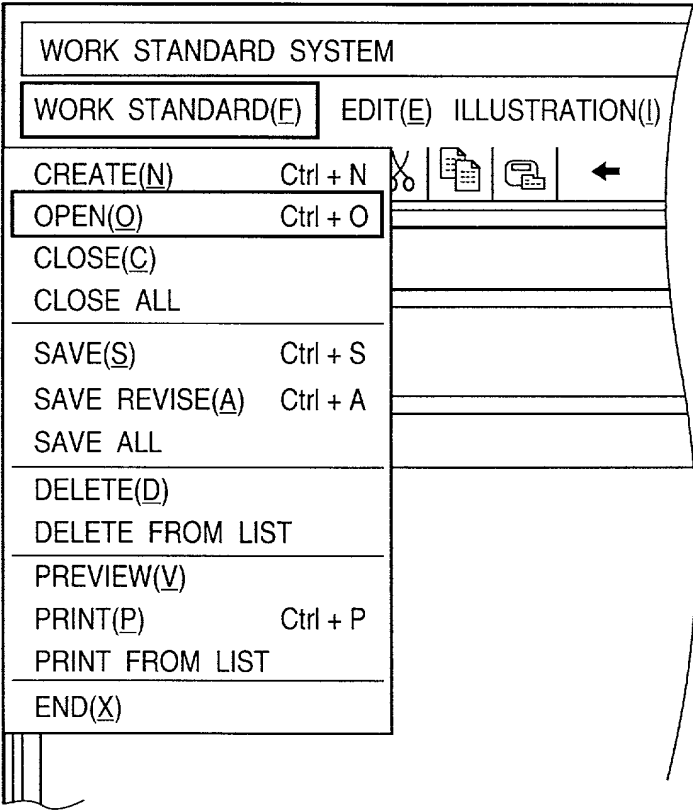


FIG. 23

WORK STANDARD SYSTEM

◎ LATEST REVISION NUMBER

○ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	ASFu取付	1997/09/13
SO - 01 - 01(3) - E	01	ベース・トレ- <u>u</u> 取付	1997/09/01
SO - 01 - 03 - E	01	ベース・トレ- <u>u</u> 取付	1997/09/01
SO - 01 - 04 - E	01	ベース・トレ- <u>u</u> 取付	1997/09/01

SO - 06 - 01 - E

SO - 06 - 02 - E

SO - 06 - 03 - E

SO - 07 - 01(2) - E

SO - 08 - 01 - E

線処理

線処理

線処理

レールグリス塗布

レール取付

1997/09/01

1997/09/01

1997/09/01

1997/09/01

1997/09/01

OK

CANCEL

2301

FIG. 24





SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
		EDIT(E)	
01 CREATE		PowerPoint	
		✓ Canvas	

FIG. 26

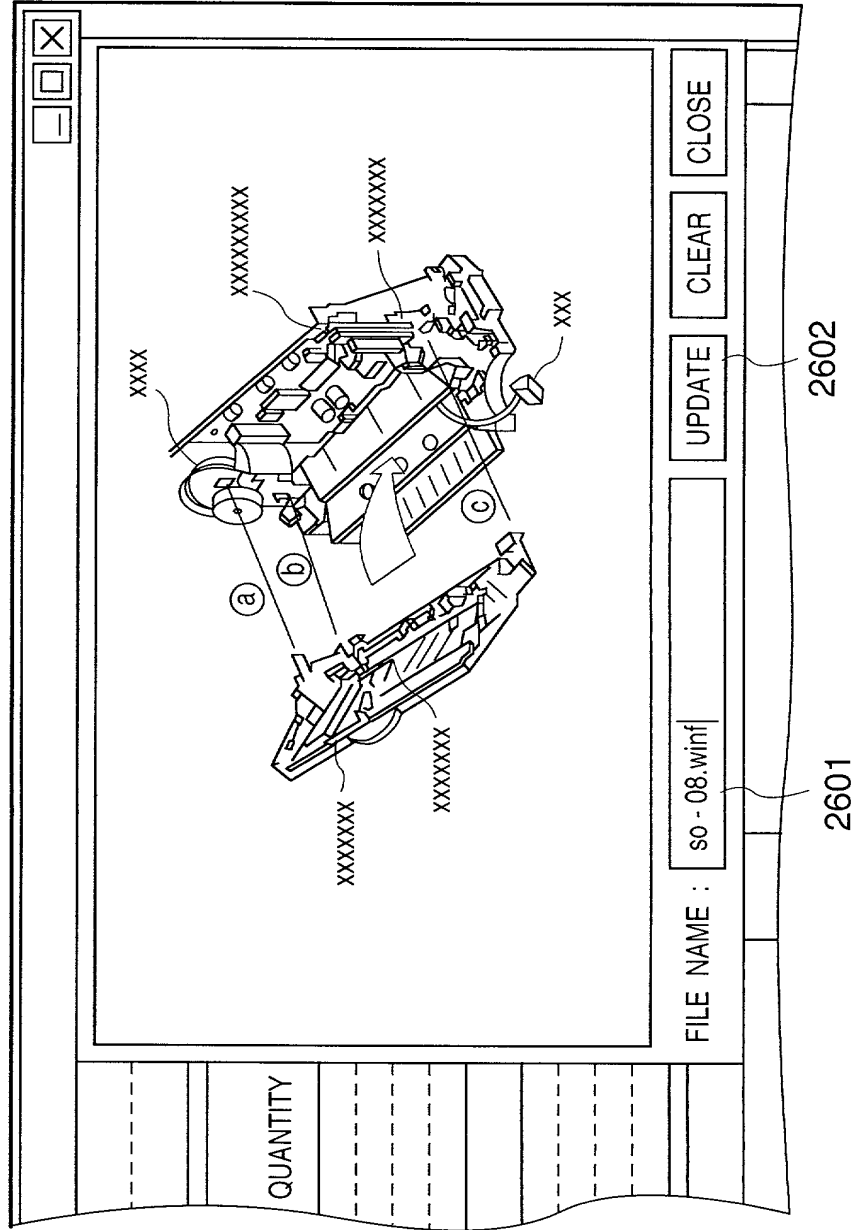


FIG. 27

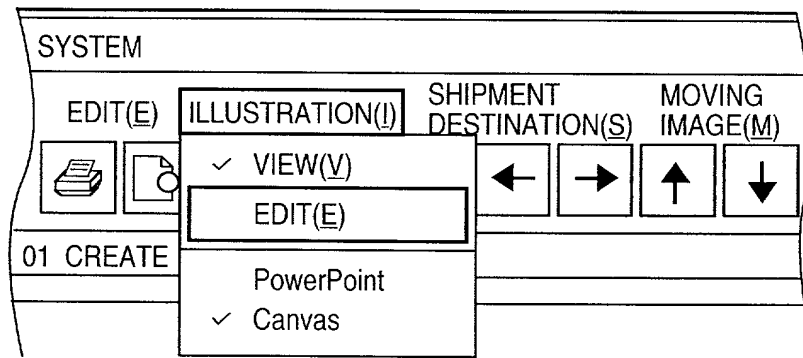


FIG. 28

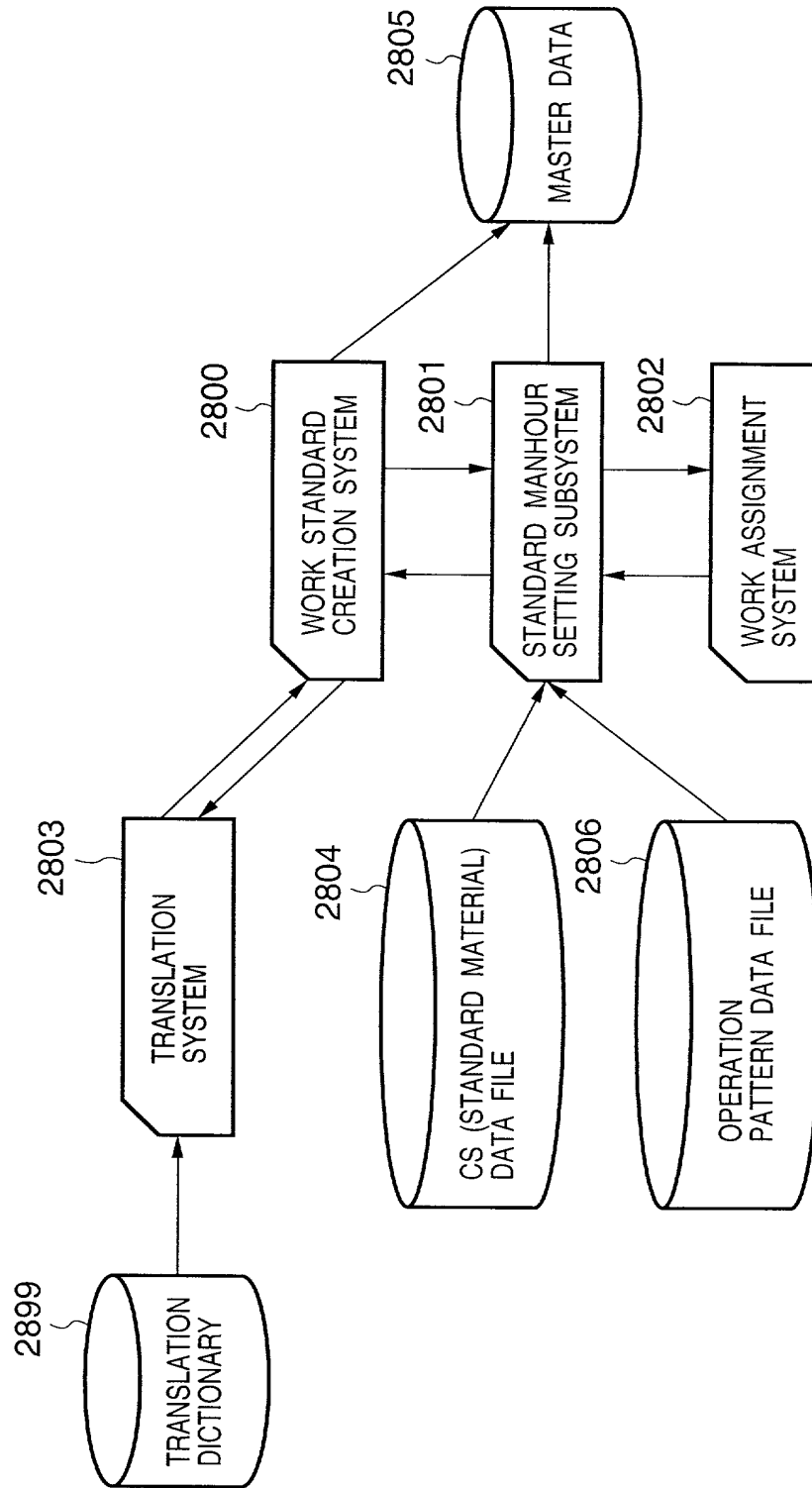


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) X

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

TOTAL

ASSEMBLY

UNIT

ASSEMBLY

DISPLAY DATA

ALL

UNTRANSLATED

UNCHECKED

DISPLAY LANGUAGE

JAPANESE

ENGLISH

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナーu取付	X	X
PT - 010 - 020	01	クリーナーu取付	X	X
PT - 010 - 030	01	クリーナーu取付	X	X
PT - 070 - 030	01	切換アームAssy組立	X	X
PT - 080 - 010	01	伝達ローラu取付	X	X
PT - 090 - 010	01	伝達ローラu取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

SELECT ALL

CANCEL SELECT

VIEW

TRANSLATE

TRANSLATE ALL

CLOSE

FIG. 32

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

01 ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

02 ブレードレバ-を矢印② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する

03 ブレードレバ-軸先端がブレードホルダ-先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE

OK

CANCEL

3200

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)

WORK STANDARD(E) ILLUSTRATION(I)

WORK STANDARD PN-030-020 01 Net

Model QG5-1317

VOICE(S)

PLAY(P)

NEW(N)

DRIVE(D)

DOWN(W)

X2056) A252 PLATEN UNIT

FIG. 34

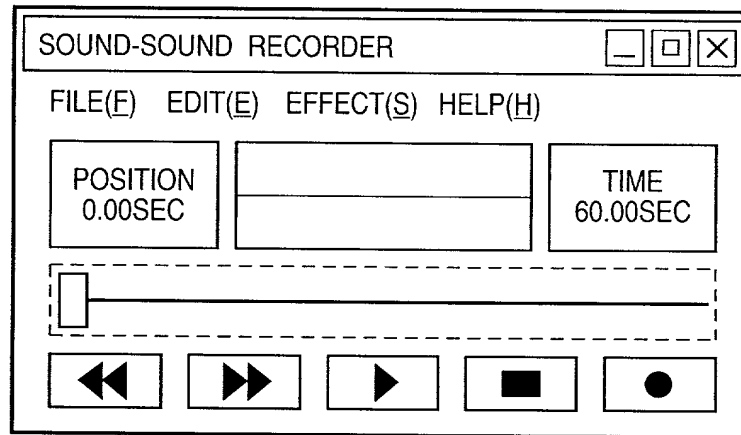


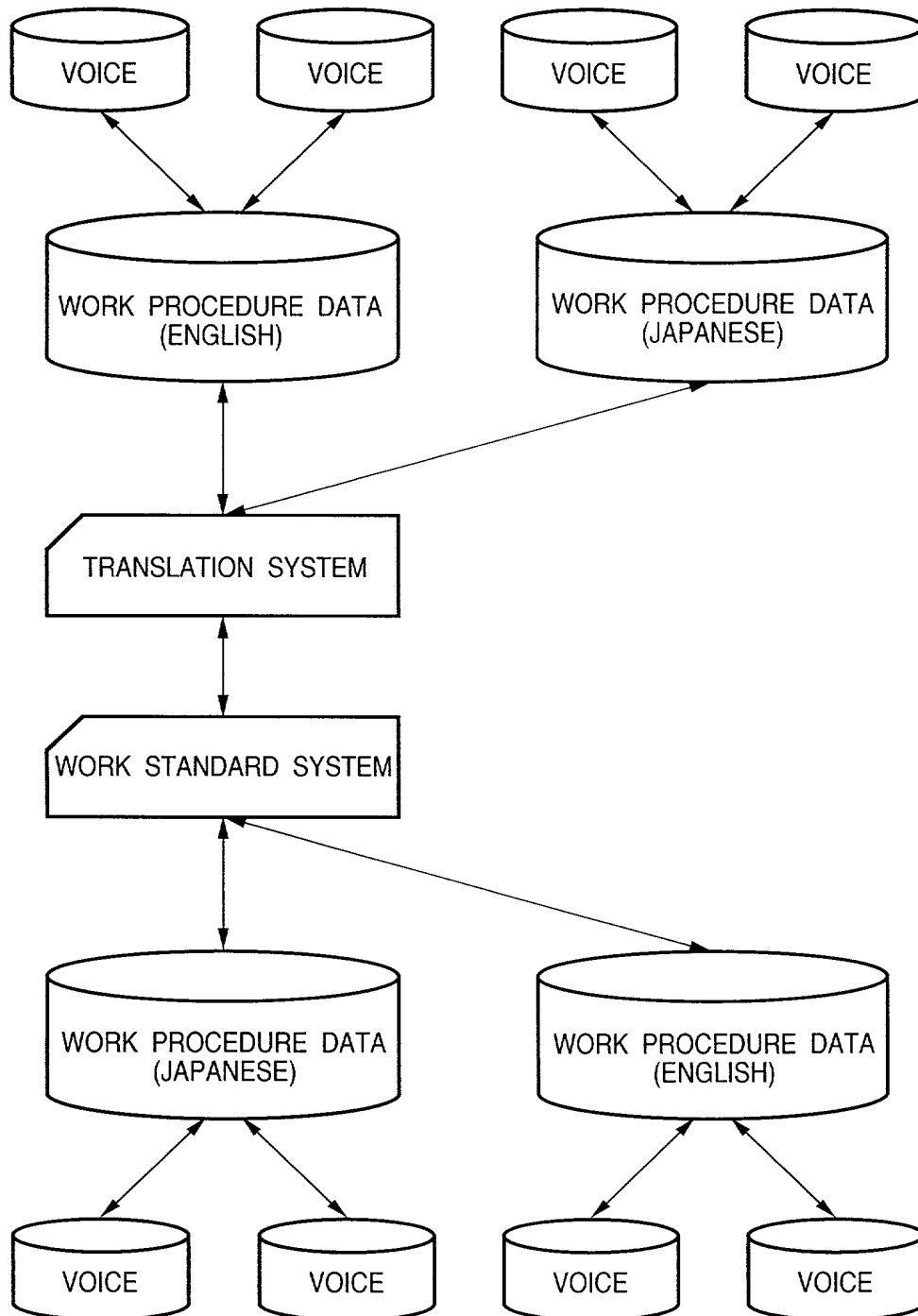
FIG. 35

FIG. 36

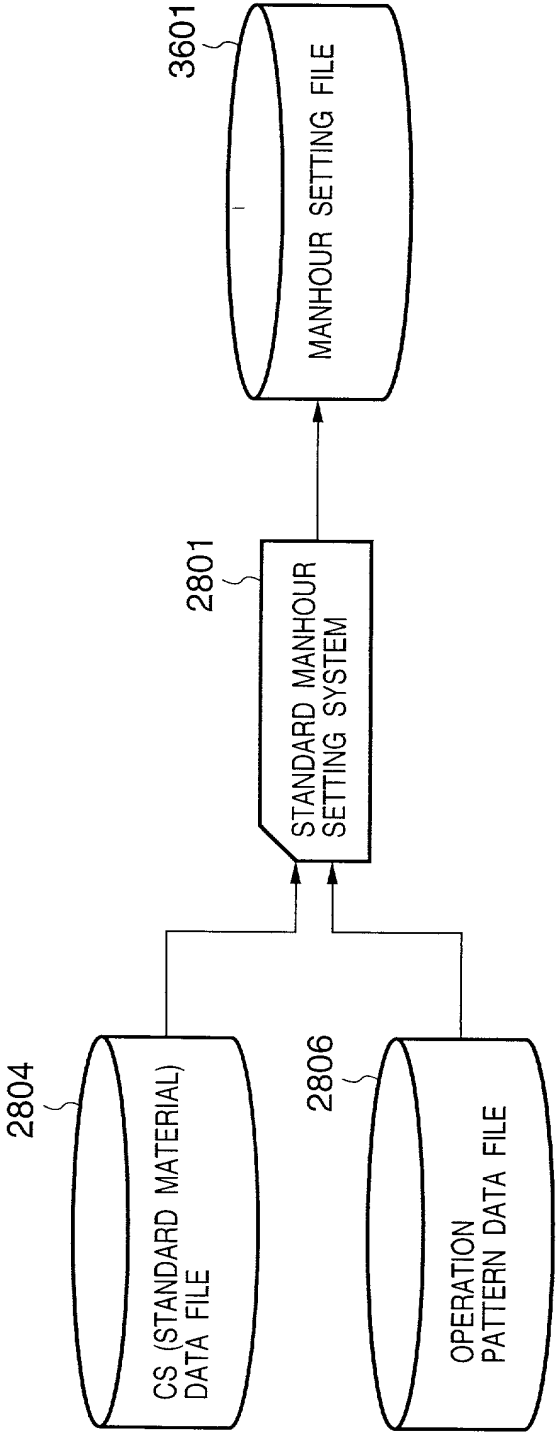


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
						I

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

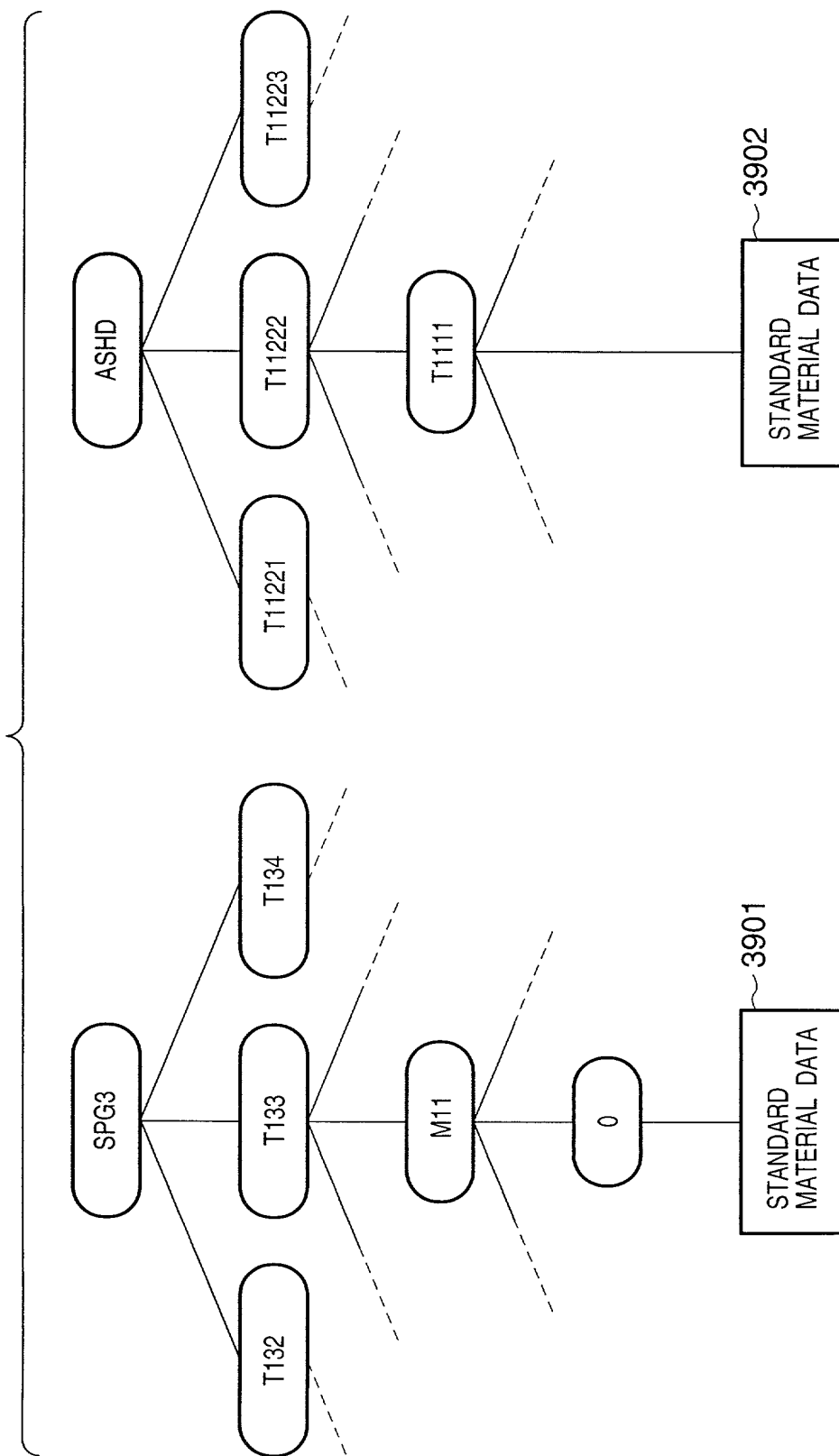
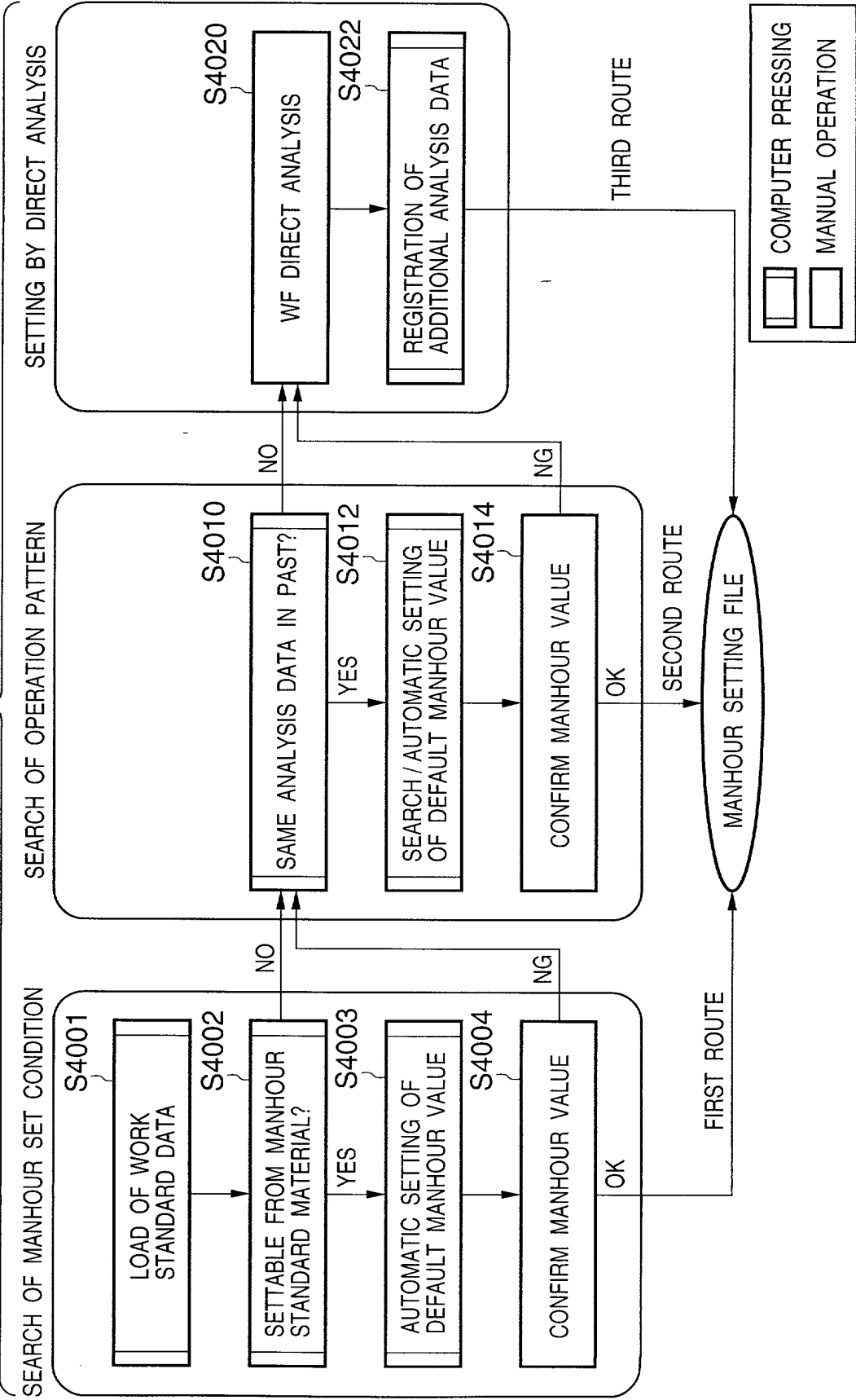


FIG. 40



[illegible]

DATA LOAD

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

FIG. 42

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	負荷バネを負荷バネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE)	1	1	8		
3	分離ロー軸を負荷バネ取付治具に取込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE)	1	1	8		
5	分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*バネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*Eリングを	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

2804

FIG. 43

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	負荷ハネを負荷ハネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
3	分離ロー軸を負荷ハネ取付治具に取込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
5	分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGト`アを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コト`を		抜く	/GET:-50EGr2/M:-10E	16RU
7		測定用電源コト`を		抜く	/GET:-50EGr2/M:-10E	16RU

2806

3601

1000000

FIG. 45

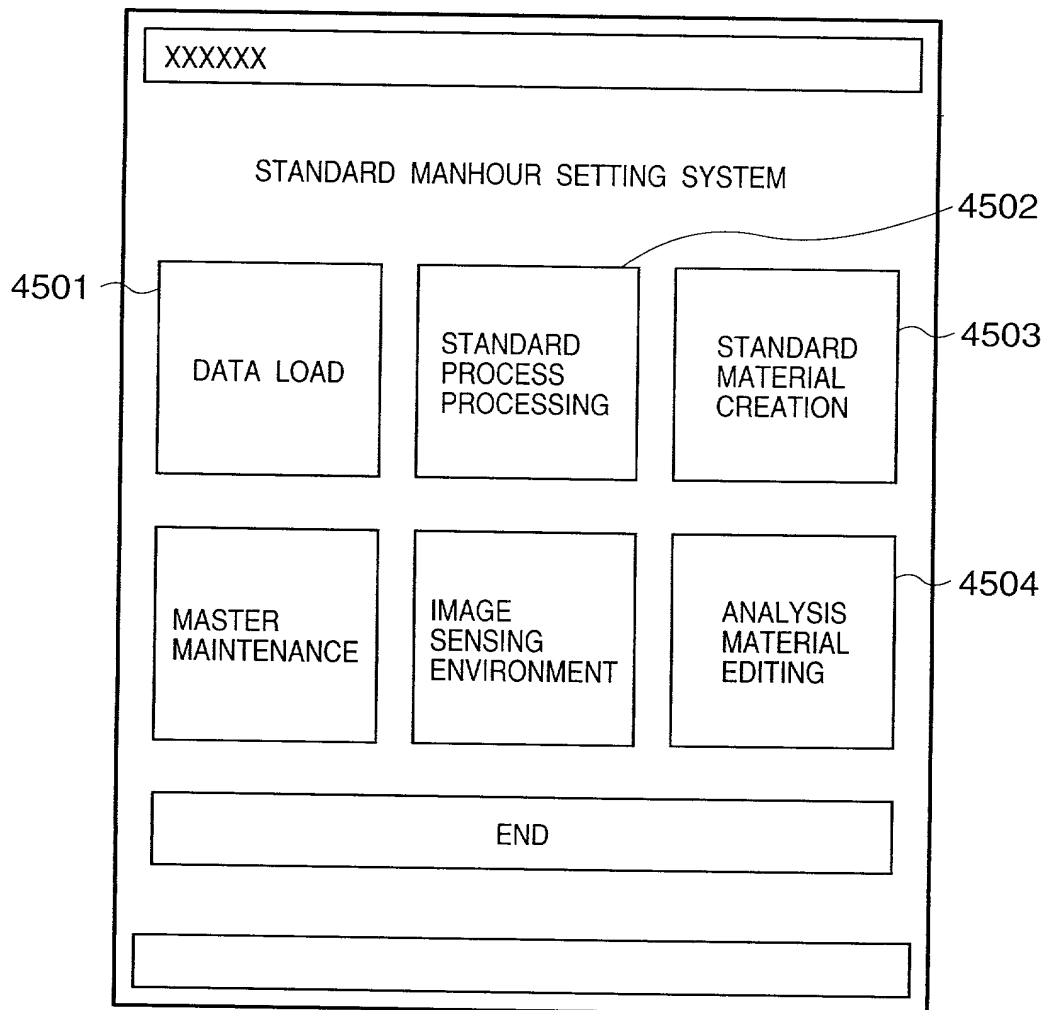


FIG. 46

4601

XXXXXX

4609 4610

ALL ☒ DESIGNATE : 1

PRODUCT NUMBER :

NAME :

OK

4612

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
xyz - test				
test - 01				
tesr - AMI				

SELECT

CANCEL

4611 4602 4603 4604 4605

FIG. 47

[illegible]

FIG. 48

4805 4804

LOAD OF DATA

4800

COMPONENT DESIGNATION

4801

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOOR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

4803

EXECUTE

CANCEL

4806

FIG. 49

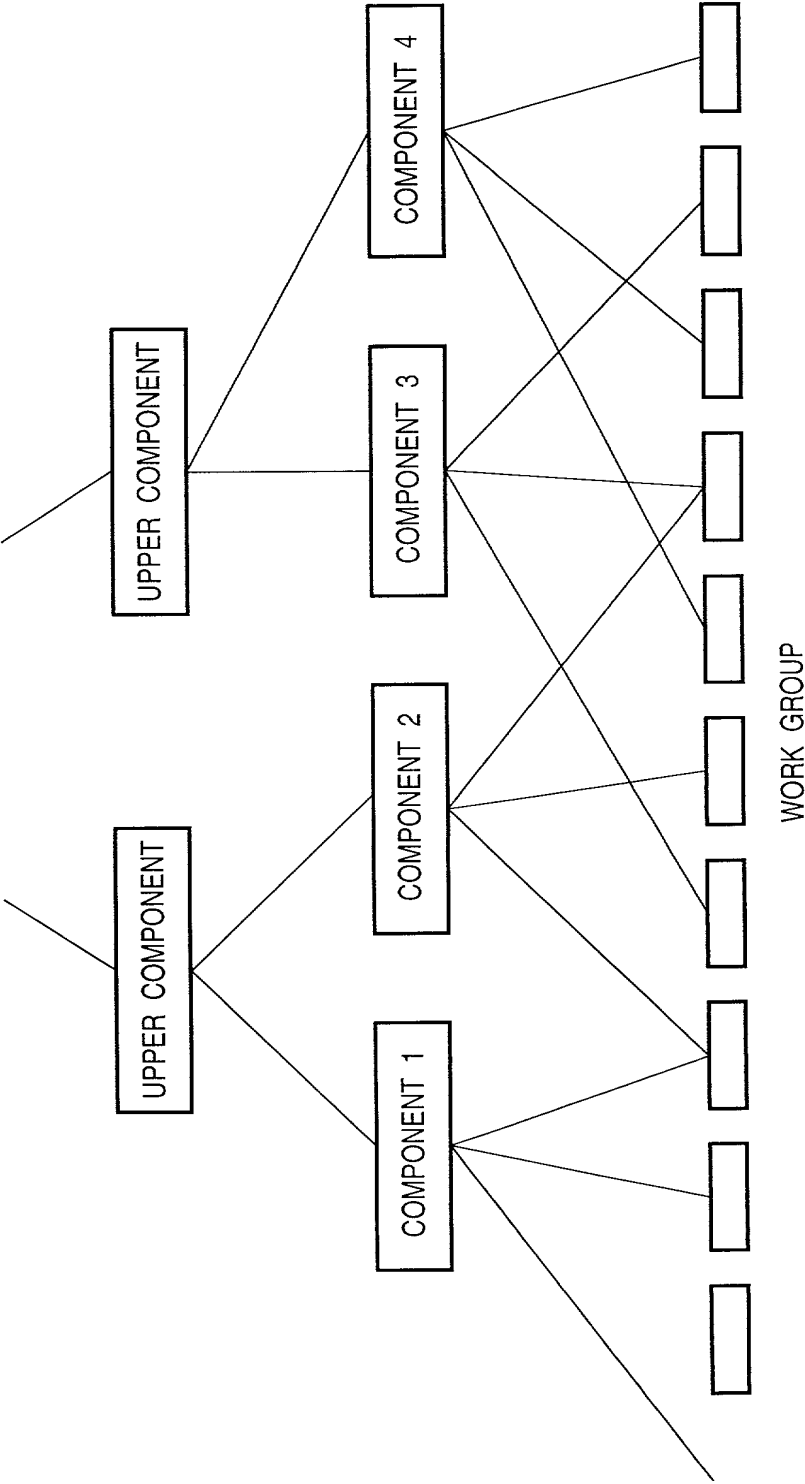


FIG. 50

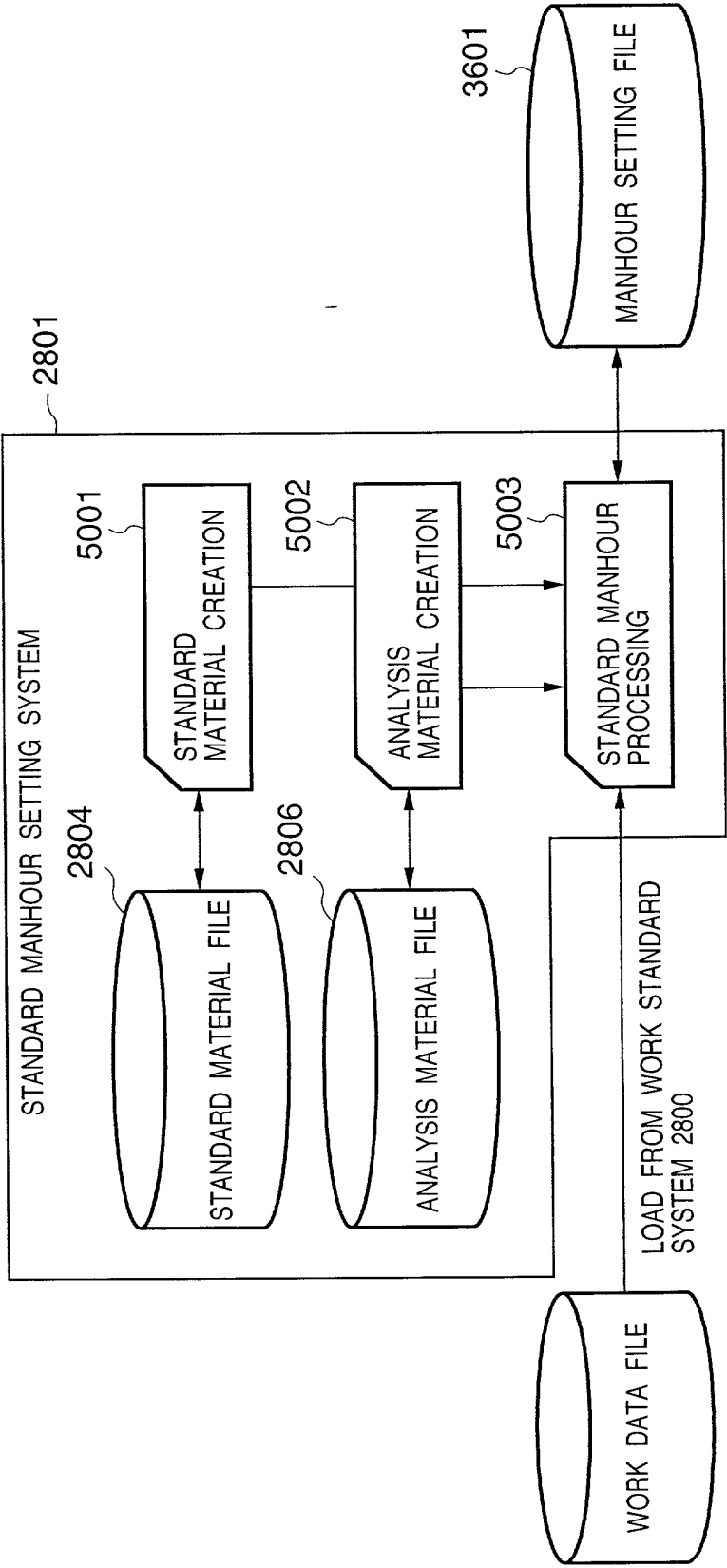
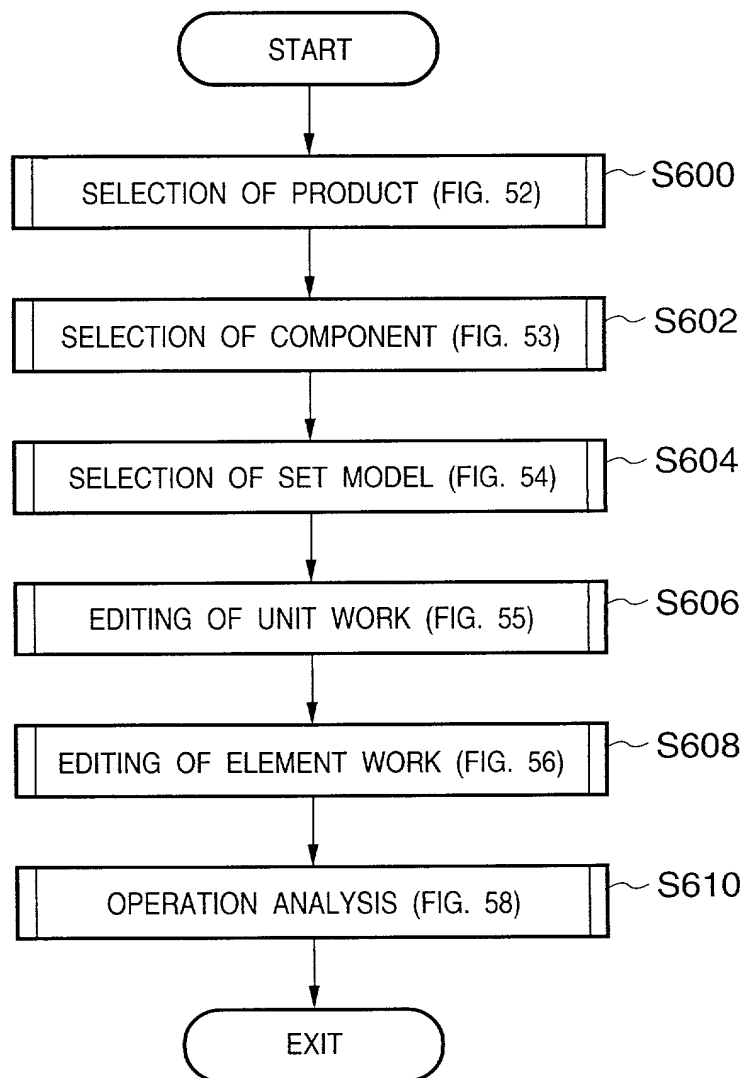


FIG. 51

[illegible]

THE **NEW** **YORK** **PUBLIC** **LIBRARY**

5501 5502 5503 5504 5505

FIG. 57



EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQUENCY	COUNT	SET DATE
▶	IA-キャプ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	97/09/09 9:52
	IA-キャプ:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	1	97/09/09 9:53
	IA-キャプ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	97/09/09 9:55
		要素作業01		動詞	-50/Gr1/N/>6/-3	15	0	1	1	97/09/10 16:34
	IA-キャプ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	97/09/10 19:09
		キャリッジロック		塗布する	Time100/Rate100	100	100	1	1	97/09/10 19:16
	モーター組立:	プリンタジャー		入れ、セットする	M211/1/10	50	1	1	1	97/09/11 17:00
		プリンタジャー		裏面にする	T1221/M2311/0/0	12	0	1	1	97/09/11 17:34
		1		1	T2221/M1211/0/1	24	0	1	1	97/09/11 17:20
		2		2	T1221/M2311/0/0	12	0	1	1	97/09/11 17:24
		プリンタジャー	PRカイト`取付る	セットする		15	0	1	1	97/09/12 11:24
		dgdafdfas		fdasfdasfdasfd	*	16	0	1	1	97/09/12 12:10
		dsdsfisdaf		fdasfdadfdas	T21121/M1111/0/1	13	0	1	1	97/09/12 12:10
		dgdafdfas		fdasfdasfdasfd	*	16	0	1	1	97/09/12 13:39
		プリンタジャー	PRカイト`取付る	セットする		15	0	1	1	97/09/12 14:00
		プリンタジャー	PRカイト`取付る	セットする		15	0	1	1	97/09/12 14:00
		プリンタユニット		セットする	Time100/Rate100	100	100	1	1	97/09/12 14:04

FIG. 59

5901

1. PU

2. GET

3. M

4. MA

5. ASY

6. DSY

7. R

8. UMAC

9. MP

10. BODY

11. PU

12. GET

13. M

14. MA

15. ASY

16. DSY

17. R

☐ SIMO

SELECT

CANCEL

5902

FIG. 60

XXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

FIG. 61

FORMULA

TURNCHANGE DIRECTION OF BODYMANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

6101

6104

6103

6102

6105

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains the following elements:

- VARIATION AMOUNT :** A text label followed by a rectangular input field containing the number "10".
- USE :** A text label followed by a rectangular input field containing the number "0".
- REASON CODE :** A text label followed by a small rectangular input field containing the number "1".
- CHANGE REASON :** A text label followed by a rectangular dropdown menu. The dropdown menu is currently displaying the text "SET" and has a downward-pointing arrow icon on its right side.
- Buttons:** At the bottom of the window, there are two rectangular buttons: "OK" on the left and "Clear" on the right.

Reference numerals are used to identify specific components:

- 6201 points to the title bar area.
- 6202 points to the "VARIATION AMOUNT" input field.
- 6203 points to the "USE" input field.
- 6204 points to the "CHANGE REASON" dropdown menu.
- 6205 points to the "OK" button.
- 6206 points to the "Clear" button.

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE 1997 09 22 ○ = ○ FROM
○ BEFORE ○ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOURL	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOURL	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14:30.00

REASON CODE 1 CHANGE REASON SET

OK Ctr END

FIG. 64

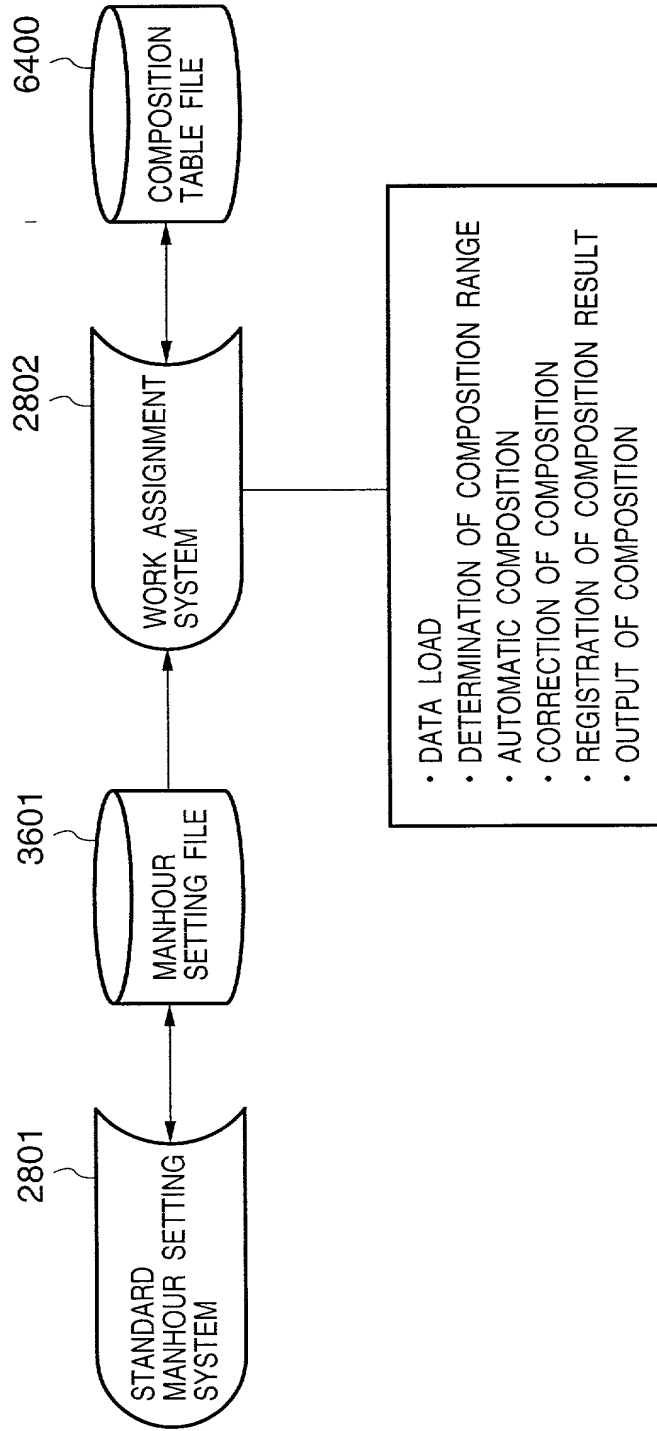


FIG. 65

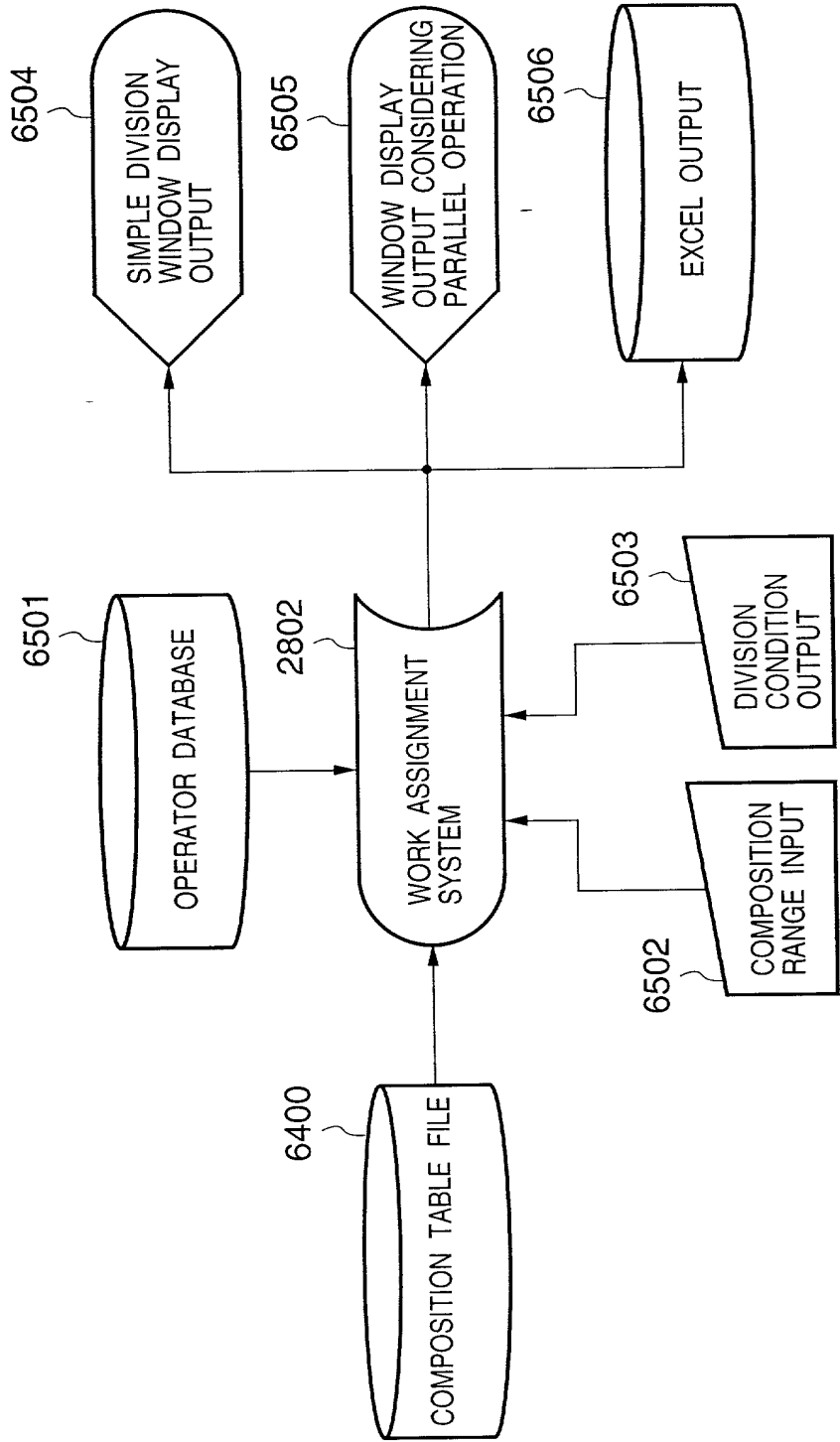


FIG. 66

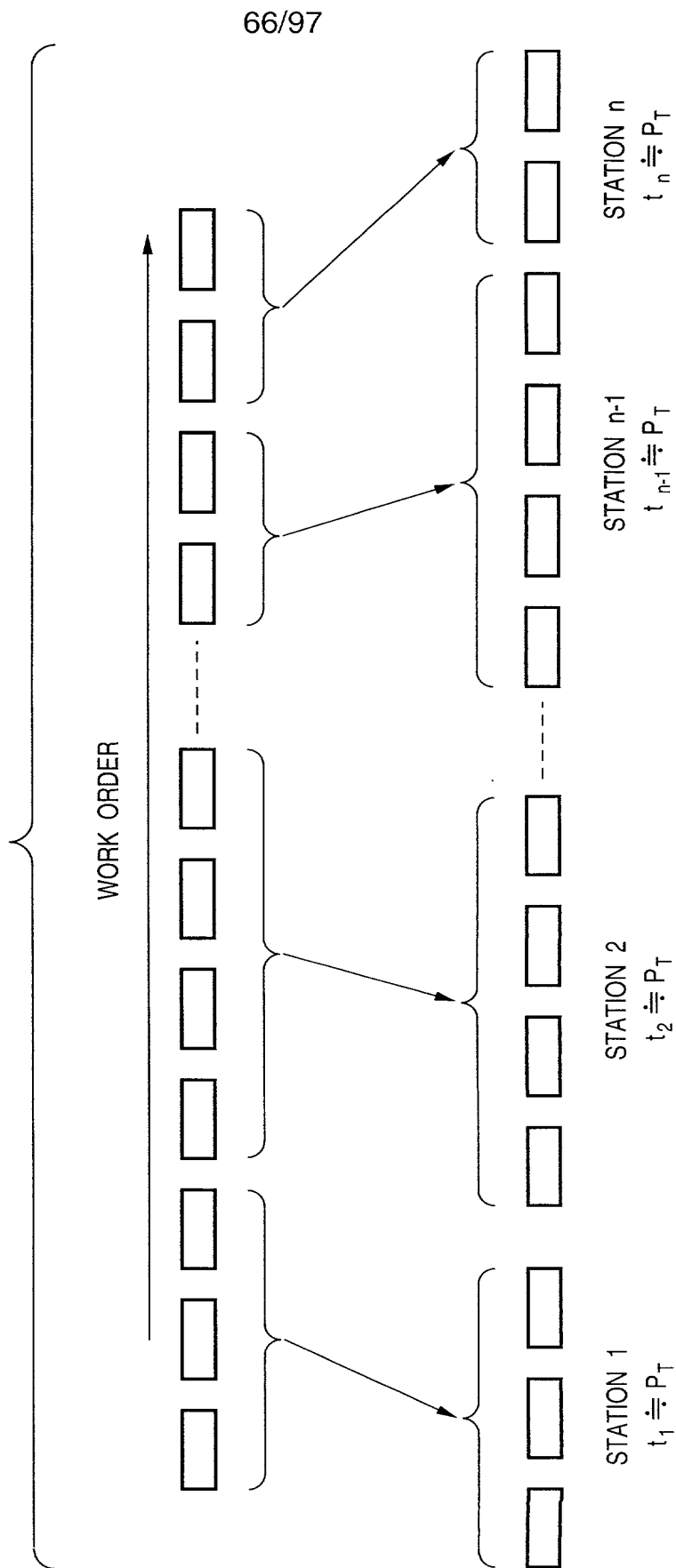


FIG. 67

FILE(F) EDIT(E) INPUT(I) TOOL(O)

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

: :

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
	FILE(F) EDIT(E)	◆	

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

FIG. 69

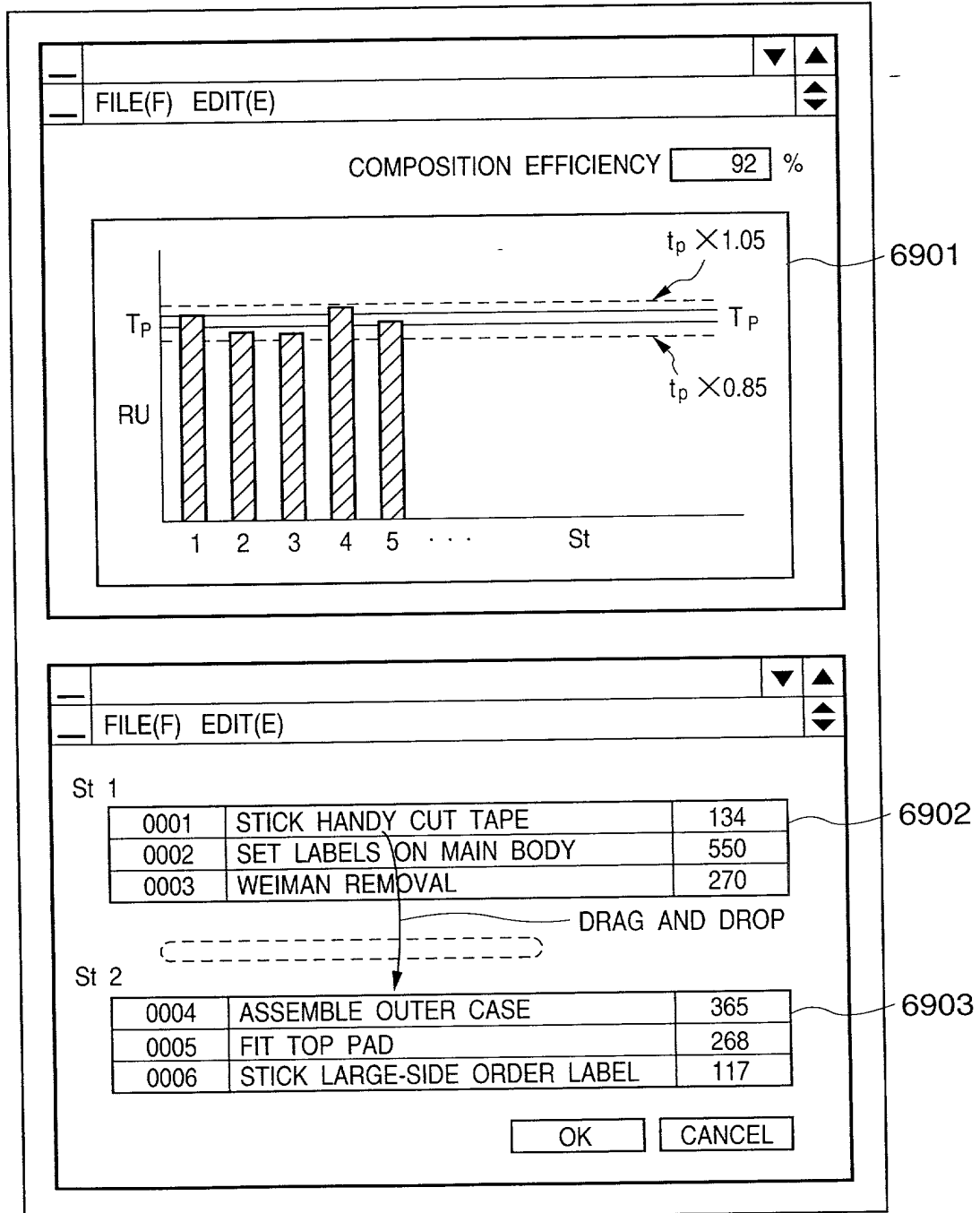


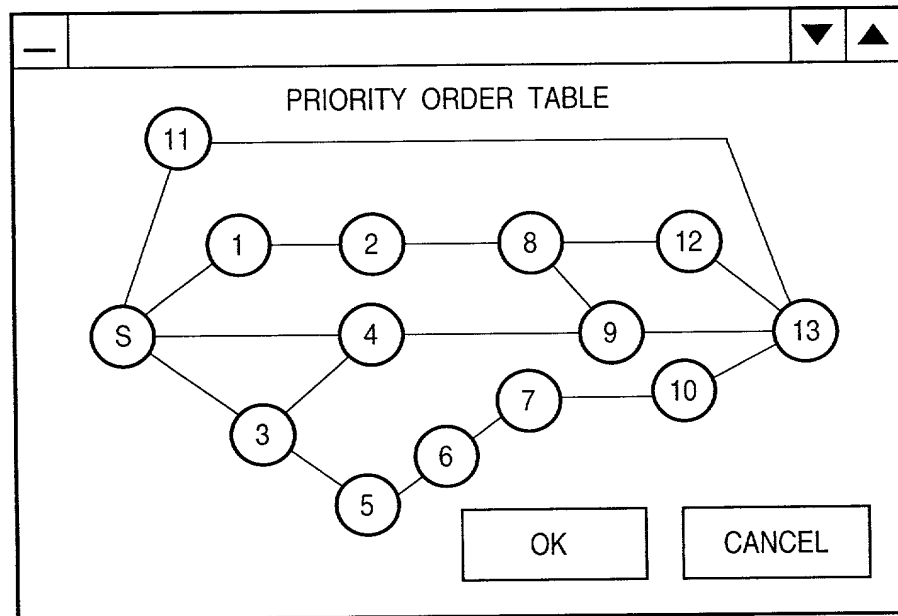
FIG. 70

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
			⋮		

FIG. 72

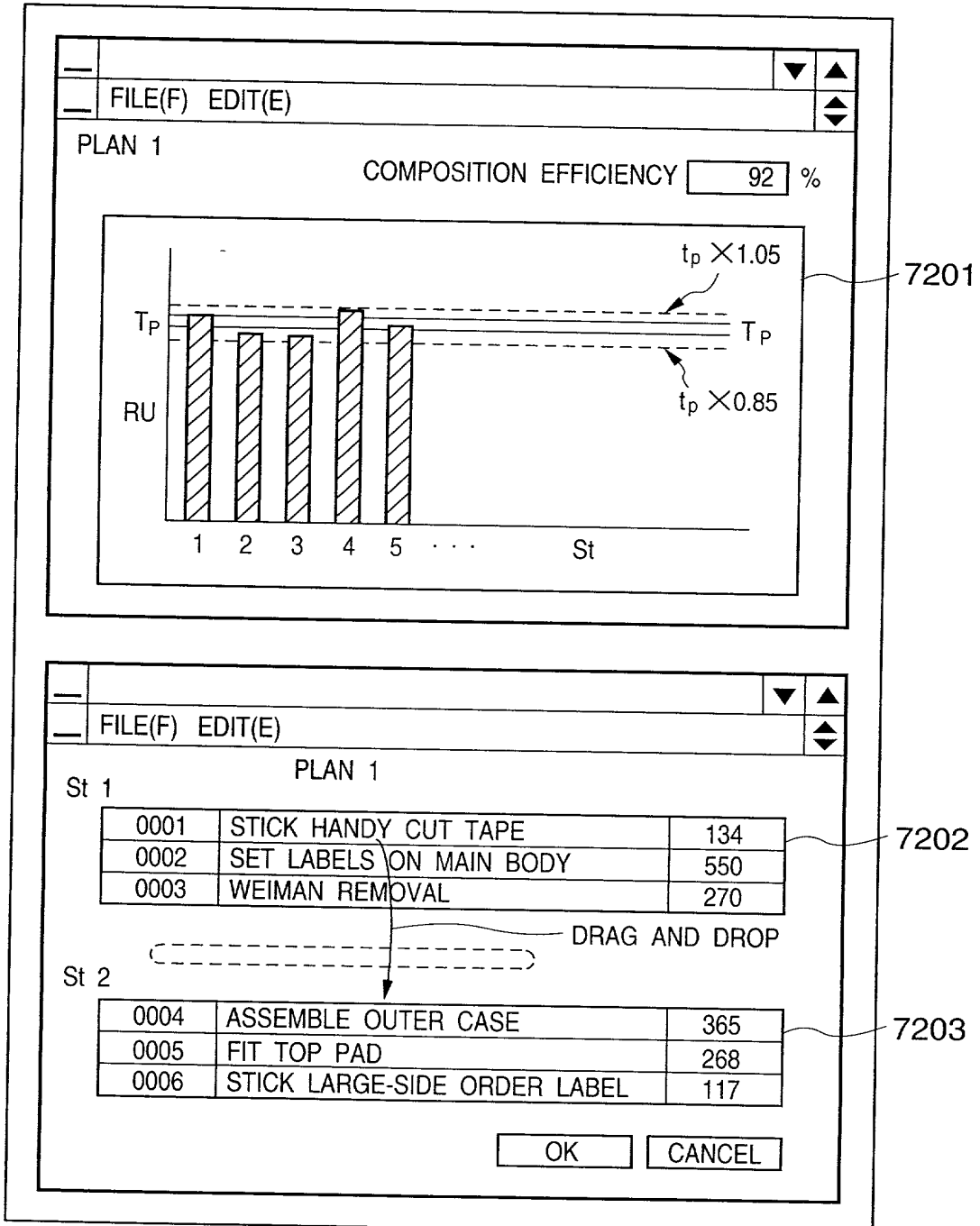


FIG. 73

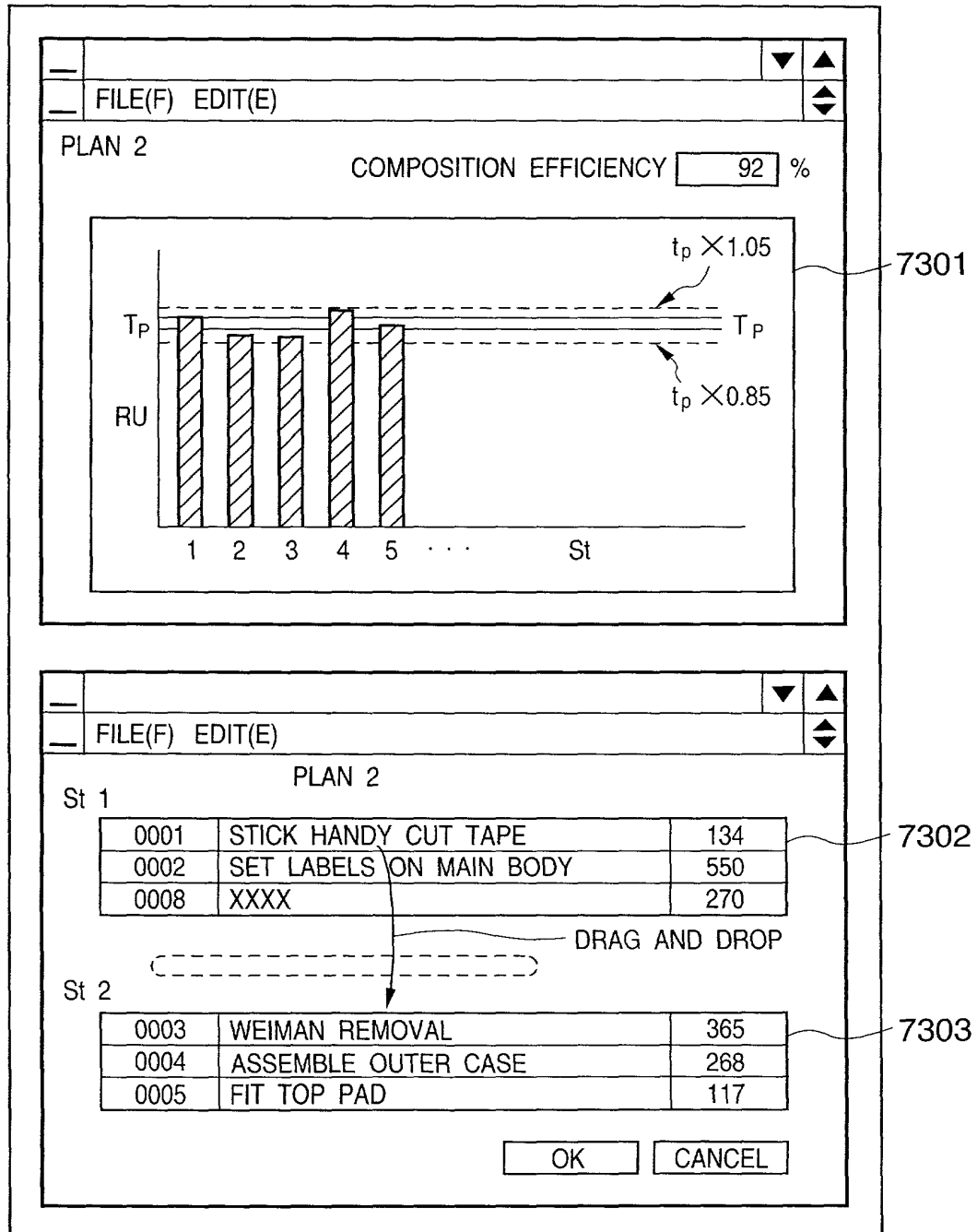


FIG. 74

74/97

7401

7402

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

7403

7404

7405

7406

7407

7409

GENRE

REPRESENTATIVE MODEL

TARGET MODEL

COMPONENT

COMPONENT	SYMBOL	COMPONENT NAME	ORDER
BJ			
FAX			
LBP			
NP			
STAND			

OK

CANCEL

7408

FIG. 75

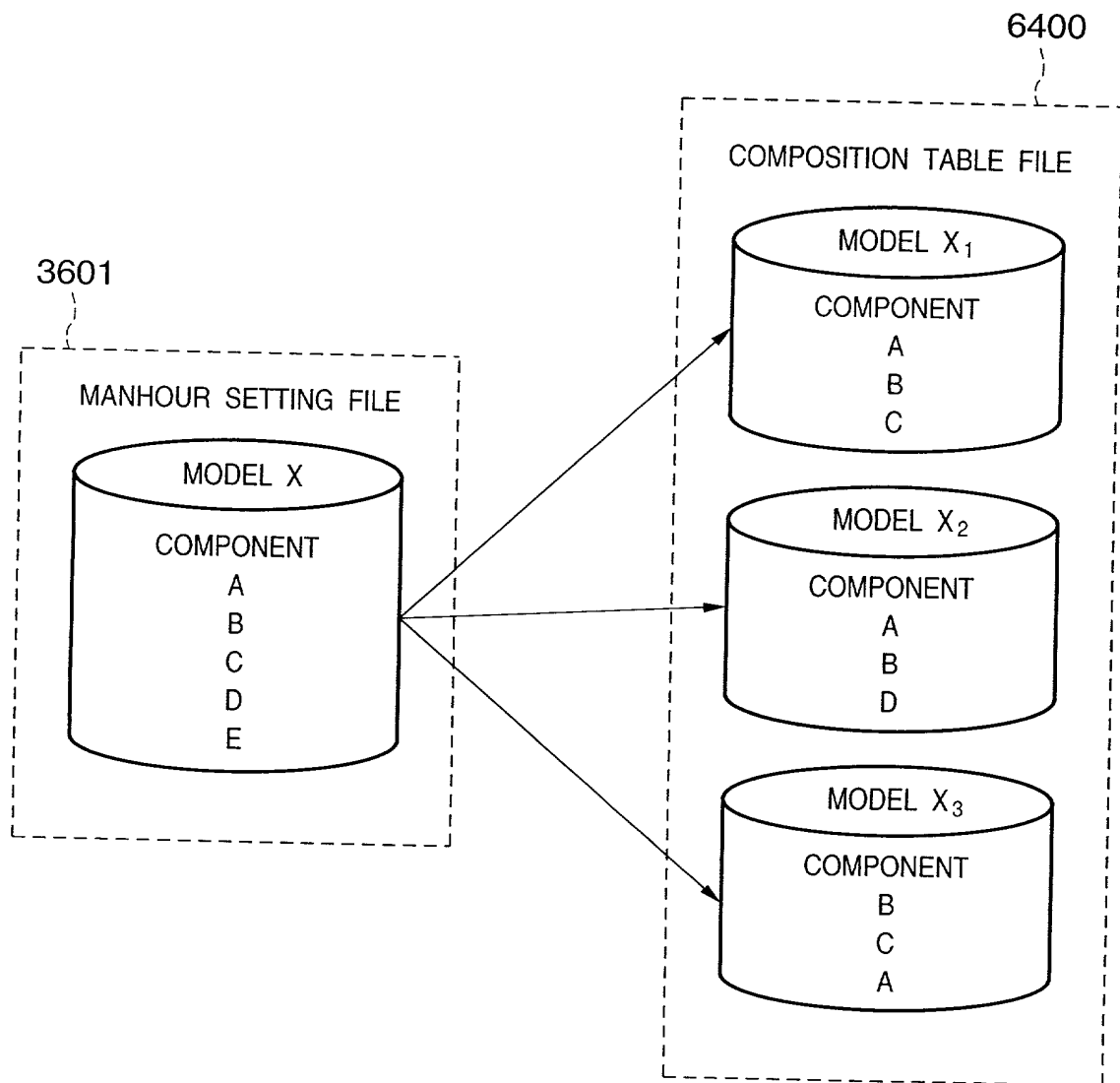


FIG. 76

7601

7602

7603

7604

7606

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv	テストデータ(元)	1	97/09/19	12:00:34
f12-0010.csv	テスト	0	97/09/19	13:27:17
BJC-4300	0	0	97/09/19	14:10:14
BJC-4300	0	0	97/09/19	14:10:32
BJC-4300		1	97/09/19	15:41:14
BJC-4300	BJC-4300Aライン編成		97/09/20	14:16:58
BJC-4300	BJC-4300Aライン編成	03	97/10/13	17:54:57
BJC-4300	BJC-4300Aライン編成	00	97/09/20	14:06:36
f12-0010.csv	f12-0010Aライン編成	05	97/09/24	17:11:53

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

FIG. 78

09753998.010374

7801

7802

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

REMARKS :

OK CANCEL

FIG. 79

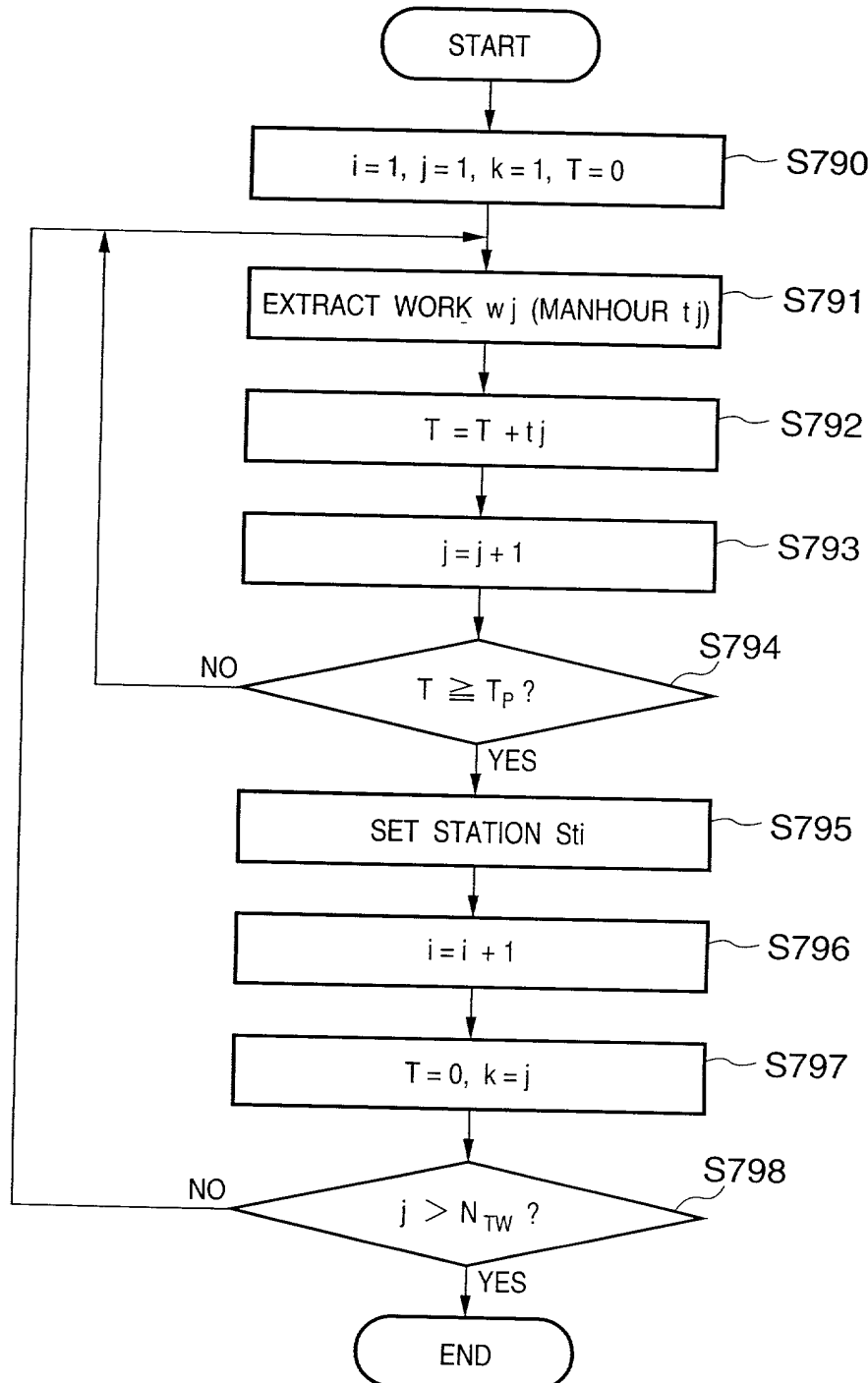


FIG. 80

FILE(F) EDIT(E) VIEW(V) TOOL(T)

8001 OPERATOR 1

8002 OPERATOR 2

8003 OPERATOR 3

8004 OPERATOR 4

8005 OPERATOR 5

8006

8007

8008

8009

8010

8011

8012

8013

8014

8015

8016

8017

8018

8019

8020

8021

8022

8023

8024

8025

8026

8027

8028

8029

8030

8031

8032

8033

8034

8035

8036

8037

8038

8039

8040

8041

8042

8043

8044

8045

8046

8047

8048

8049

8050

8051

8052

8053

8054

8055

8056

8057

8058

8059

8060

8061

8062

8063

8064

8065

8066

8067

8068

8069

8070

8071

8072

8073

8074

8075

8076

8077

8078

8079

8080

8081

8082

8083

8084

8085

8086

8087

8088

8089

8090

8091

8092

8093

8094

8095

8096

8097

8098

8099

8100

8101

8102

8103

8104

8105

8106

8107

8108

8109

8110

8111

8112

8113

8114

8115

8116

8117

8118

8119

8120

8121

8122

8123

8124

8125

8126

8127

8128

8129

8130

8131

8132

8133

8134

8135

8136

8137

8138

8139

8140

8141

8142

8143

8144

8145

8146

8147

8148

8149

8150

8151

8152

8153

8154

8155

8156

8157

8158

8159

8160

8161

8162

8163

8164

8165

8166

8167

8168

8169

8170

8171

8172

8173

8174

8175

8176

8177

8178

8179

8180

8181

8182

8183

8184

8185

8186

8187

8188

8189

8190

8191

8192

8193

8194

8195

8196

8197

8198

8199

8200

8201

8202

8203

8204

8205

8206

8207

8208

8209

8210

8211

8212

8213

8214

8215

8216

8217

8218

8219

8220

8221

8222

8223

8224

8225

8226

8227

8228

8229

8230

8231

8232

8233

8234

8235

8236

8237

8238

8239

8240

8241

8242

8243

8244

8245

8246

8247

8248

8249

8250

8251

8252

8253

8254

8255

8256

8257

8258

8259

8260

8261

8262

8263

8264

8265

8266

8267

8268

8269

8270

8271

8272

8273

8274

8275

8276

8277

8278

8279

8280

8281

8282

8283

8284

8285

8286

8287

8288

8289

8290

8291

8292

8293

8294

8295

8296

8297

8298

8299

8300

8301

8302

8303

8304

8305

8306

8307

8308

8309

8310

8311

8312

8313

8314

8315

8316

8317

8318

8319

8320

8321

8322

8323

8324

8325

8326

8327

8328

8329

8330

8331

8332

8333

8334

8335

8336

8337

8338

8339

8340

8341

8342

8343

8344

8345

8346

8347

8348

8349

8350

8351

8352

8353

8354

8355

8356

8357

8358

8359

8360

8361

8362

8363

8364

8365

8366

8367

8368

8369

8370

8371

8372

8373

8374

8375

8376

8377

8378

8379

8380

8381

8382

8383

8384

8385

8386

8387

8388

8389

8390

8391

8392

8393

8394

8395

8396

8397

8398

8399

8400

8401

8402

8403

8404

8405

8406

8407

8408

8409

8410

8411

8412

8413

8414

8415

8416

8417

8418

8419

8420

8421

8422

8423

8424

8425

8426

8427

8428

8429

8430

8431

8432

8433

8434

8435

8436

8437

8438

8439

8440

8441

8442

8443

8444

8445

8446

8447

8448

8449

8450

8451

8452

8453

8454

8455

8456

8457

8458

8459

8460

8461

8462

8463

8464

8465

8466

8467

8468

8469

8470

8471

8472

8473

8474

8475

8476

8477

8478

8479

8480

8481

8482

8483

8484

8485

8486

8487

8488

8489

8490

8491

8492

8493

8494

8495

8496

8497

8498

8499

8500

8501

8502

8503

8504

8505

8506

8507

8508

8509

8510

8511

8512

8513

8514

8515

8516

8517

8518

8519

8520

8521

8522

8523

8524

8525

8526

8527

8528

8529

8530

8531

8532

8533

8534

8535

8536

8537

8538

8539

8540

8541

8542

8543

8544

8545

8546

8547

8548

8549

8550

8551

8552

8553

8554

8555

8556

8557

8558

8559

8560

8561

8562

8563

8564

8565

8566

8567

8568

8569

8570

8571

8572

8573

8574

8575

8576

8577

8578

8579

8580

8581

8582

8583

8584

8585

8586

8587

8588

8589

8590

8591

8592

8593

8594

8595

8596

8597

8598

8599

8600

8601

8602

8603

8604

8605

8606

8607

8608

8609

8610

8611

8612

8613

8614

8615

8616

8617

8618

8619

8620

8621

8622

8623

8624

8625

8626

8627

8628

8629

8630

8631

8632

8633

8634

8635

8636

8637

8638

8639

8640

8641

8642

8643

8644

8645

8646

8647

8648

8649

8650

8651

8652

8653

8654

8655

8656

8657

8658

8659

8660

8661

8662

8663

8664

8665

8666

8667

8668

8669

8670

8671

8672

8673

8674

8675

8676

8677

8678

8679

8680

8681

8682

8683

8684

8685

8686

8687

8688

8689

8690

8691

8692

8693

8694

8695

8696

8697

8698

8699

8700

8701

8702

8703

8704

8705

8706

8707

8708

8709

8710

8711

8712

8713

8714

8715

8716

8717

8718

8719

8720

8721

8722

8723

8724

8725

8726

8727

8728

8729

8730

8731

8732

8733

8734

8735

8736

8737

8738

8739

8740

8741

8742

8743

8744

8745

8746

8747

8748

8749

8750

8751

8752

8753

8754

8755

8756

8757

8758

8759

8760

8761

8762

8763

8764

8765

8766

8767

8768

8769

8770

8771

8772

8773

8774

8775

8776

8777

8778

8779

8780

8781

8782

8783

8784

8785

8786

8787

8788

8789

8790

8791

8792

8793

8794

8795

8796

8797

8798

8799

8800

8801

8802

8803

8804

8805

8806

8807

8808

8809

8810

8811

8812

8813

8814

8815

8816

8817

8818

8819

8820

8821

8822

8823

8824

8825

8826

8827

8828

8829

8830

8831

8832

8833

8834

8835

8836

8837

8838

8839

8840

8841

8842

8843

8844

8845

8846

8847

8848

8849

8850

8851

8852

8853

8854

8855

8856

8857

8858

8859

8860

8861

8862

8863

8864

8865

8866

8867

8868

8869

8870

8871

8872

8873

8874

8875

8876

8877

8878

8879

8880

8881

8882

8883

8884

8885

8886

8887

8888

8889

8890

8891

8892

8893

8894

8895

8896

8897

8898

8899

8900

8901

8902

8903

8904

8905

8906

8907

8908

8909

8910

8911

8912

8913

8914

8915

8916

8917

8918

8919

8920

8921

8922

8923

8924

8925

8926

8927

8928

8929

8930

8931

8932

8933

8934

8935

8936

8937

8938

8939

8940

8941

8942

8943

8944

8945

8946

8947

8948

8949

8950

8951

8952

8953

8954

8955

8956

8957

8958

8959

8960

8961

8962

8963

8964

8965

8966

8967

8968

8969

8970

8971

8972

8973

8974

8975

8976

8977

8978

8979

8980

8981

8982

8983

8984

8985

8986

8987

8988

8989

8990

8991

8992

8993

8994

8995

8996

8997

8998

8999

9000

9001

9002

9003

9004

9005

9006

9007

9008

9009

9010

9011

9012

9013

9014

9015

9016

9017

9018

9019

9020

9021

9022

9023

9024

9025

9026

9027

9028

9029

9030

9031

9032

9033

9034

9035

9036

9037

9038

9039

9040

9041

9042

9043

9044

9045

9046

9047

9048

9049

9050

9051

9052

9053

9054

9055

9056

9057

9058

9059

9060

9061

9062

9063

9064

9065

9066

9067

9068

9069

9070

9071

9072

9073

9074

9075

9076

9077

9078

9079

9080

9081

9082

9083

9084

9085

9086

9087

9088

9089

9090

9091

9092

9093

9094

9095

9096

9097

9098

9099

9100

9101

9102

9103

9104

9105

9106

9107

9108

9109

9110

9111

9112

9113

9114

9115

9116

9117

9118

9119

9120

9121

9122

9123

9124

9125

9126

9127

9128

9129

9130

9131

9132

9133

9134

9135

9136

9137

9138

9139

9140

9141

9142

9143

9144

9145

9146

9147

9148

9149

9150

9151

9152

9153

9154

9155

9156

9157

9158

9159

9160

9161

9162

9163

9164

9165

9166

9167

9168

9169

9170

9171

9172

9173

9174

9175

9176

9177

9178

9179

9180

9181

9182

9183

9184

9185

9186

9187

9188

9189

9190

9191

9192

9193

9194

9195

9196

9197

9198

9199

9200

9201

9202

9203

9204

9205

9206

9207

9208

9209

9210

9211

9212

9213

9214

9215

9216

9217

9218

9219

9220

9221

9222

9223

9224

9225

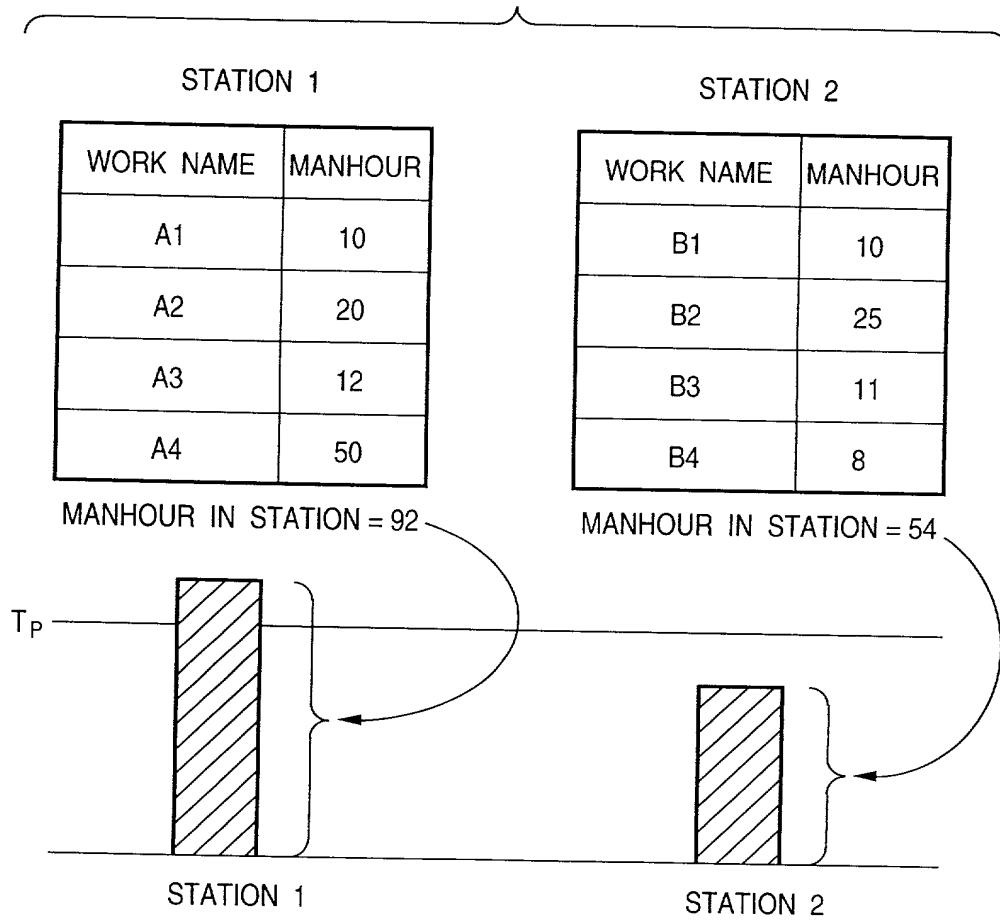
FIG. 81

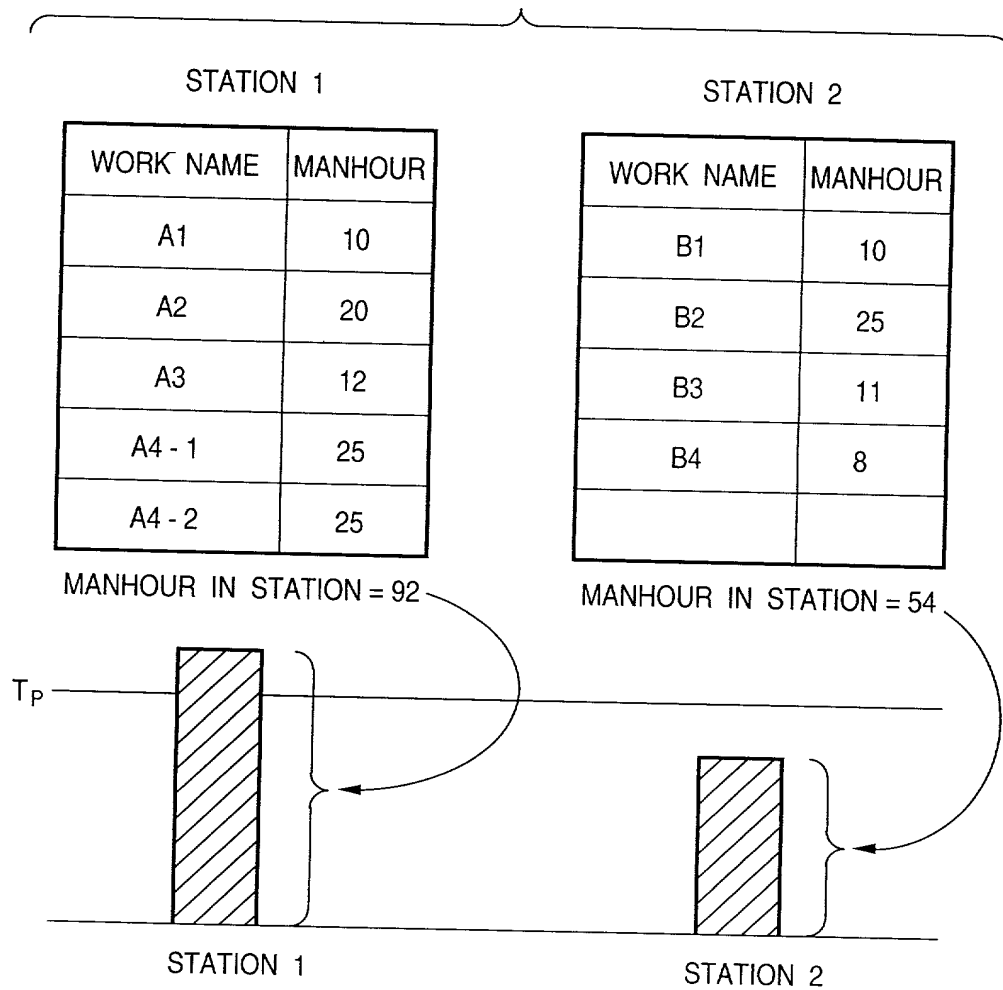
FIG. 82

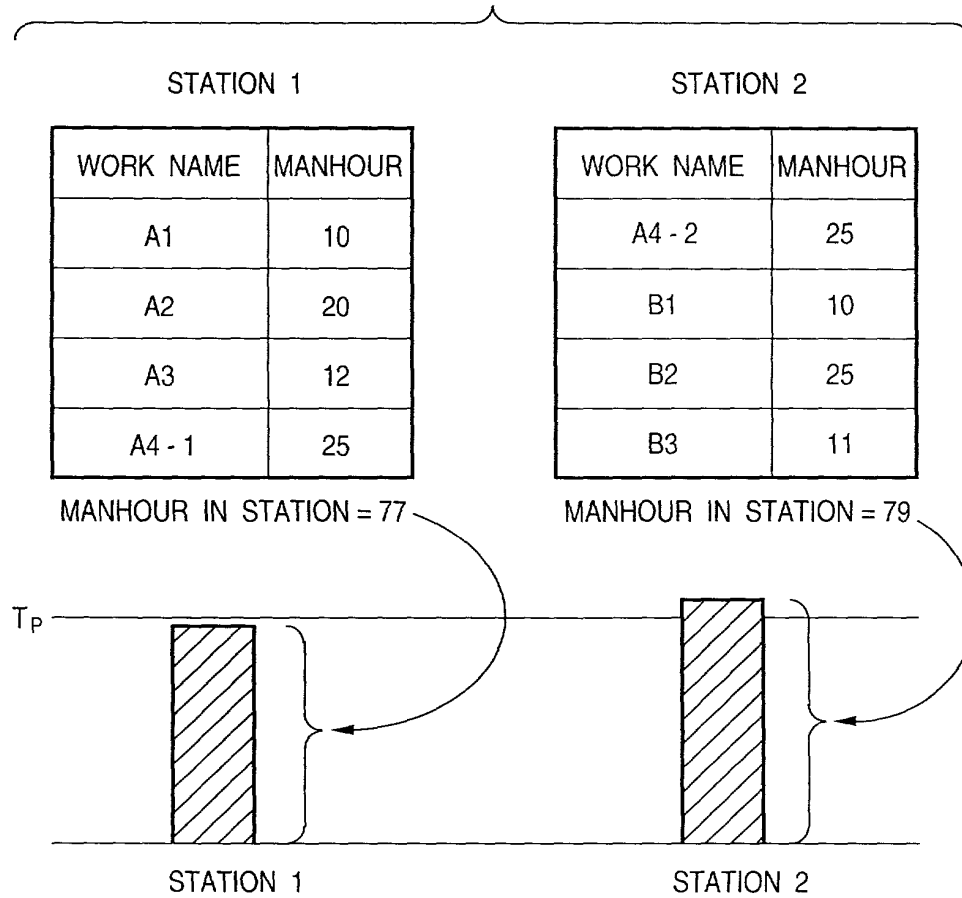
FIG. 83

FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

THE NUMBER OF STATIONS 2

OK CANCEL

8401 8402

FIG. 85

OPERATOR 1

Sl1

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
START	0	0	No	
UNIT WORK NAME 1	34	10	No 01	
UNIT WORK NAME 2	255	46	No 02	
UNIT WORK NAME 6	92	26	No 06	
UNIT WORK NAME 7	52	0	No 07	
UNIT WORK NAME 8	52	0	No 06	
UNIT WORK NAME 9	0	36	No 09	

TOTAL 585 (RU)

PF 83.6%

OPERATOR 2

Sl2

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 3	156	0	No 03	
UNIT WORK NAME 4	34	0	No 04	
UNIT WORK NAME 5	138	23	No 06	
UNIT WORK NAME 10	71	48	No 10	
UNIT WORK NAME 11	138	30	No 11	
UNIT WORK NAME 12	97	20	No 12	
UNIT WORK NAME 13	88	0	No 14	
UNIT WORK NAME 14	46	18	No 15	
UNIT WORK NAME 15	546	15	No 16	
UNIT WORK NAME 17	58	20	No 17	

TOTAL 1548 (RU) xxxxxx

PF 23.5%

OPERATOR 3

Sl3

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 13	30	40	No 13	
UNIT WORK NAME 16	303	131	No 18	

TOTAL 572 (RU)

PF 96.7%

OPERATOR 4

Sl4

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 19	84	26	No 19	
UNIT WORK NAME 20	120	20	No 20	
UNIT WORK NAME 21	310	66	No 21	

TOTAL 623 (RU)

PF 95.2%

OPERATOR 5

Sl5

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 22	146	71	No 22	
UNIT WORK NAME 23	106	26	No 23	
UNIT WORK NAME 24	61	0	No 24	
UNIT WORK NAME 25	51	10	No 25	
END	0	0	No X	

TOTAL 486 (RU)

PF 73.6%

PARALLEL STATIONS

1

2

3

4

5

900

720

540

360

180

0

----- tp

----- tp*1.05

----- tp*0.85

----- t

G STANDARD NO

WORK NAME

WF

MEANS

MA-CHINE

PROVISIONAL MANHOUR

REMARKS

COMPOSITION EFFICIENCY

116

%

NET COMPOSITION EFFICIENCY

%

COMPOSITION MODE: PRIORITY ORDER SCHEME

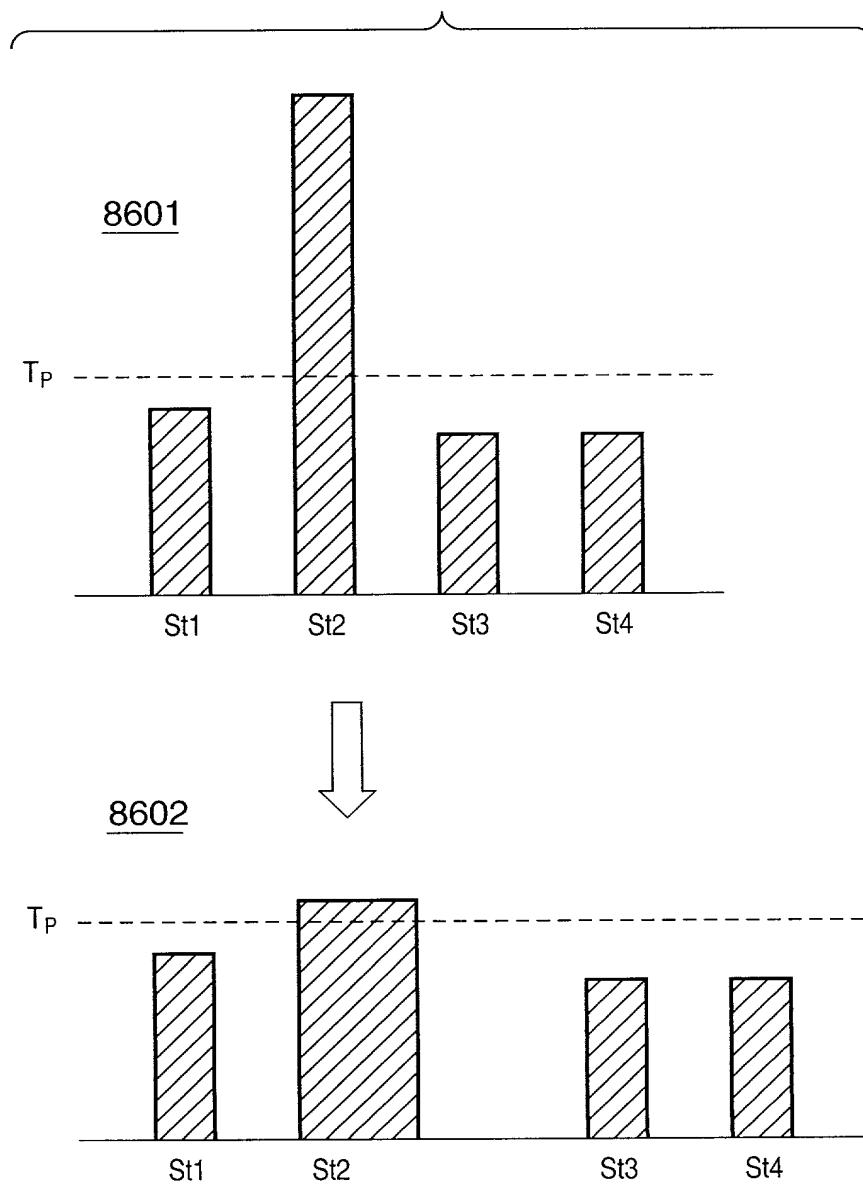
FIG. 86

FIG. 87

USER REGISTRATION

NAME CODE :

12345

8701

NAME :

田中

一郎

8702

POSITION :

kumitate

▼

8703

PASSWORD :

12345

8704

AUTHORITY :

8705

OK

CANCEL

FIG. 88

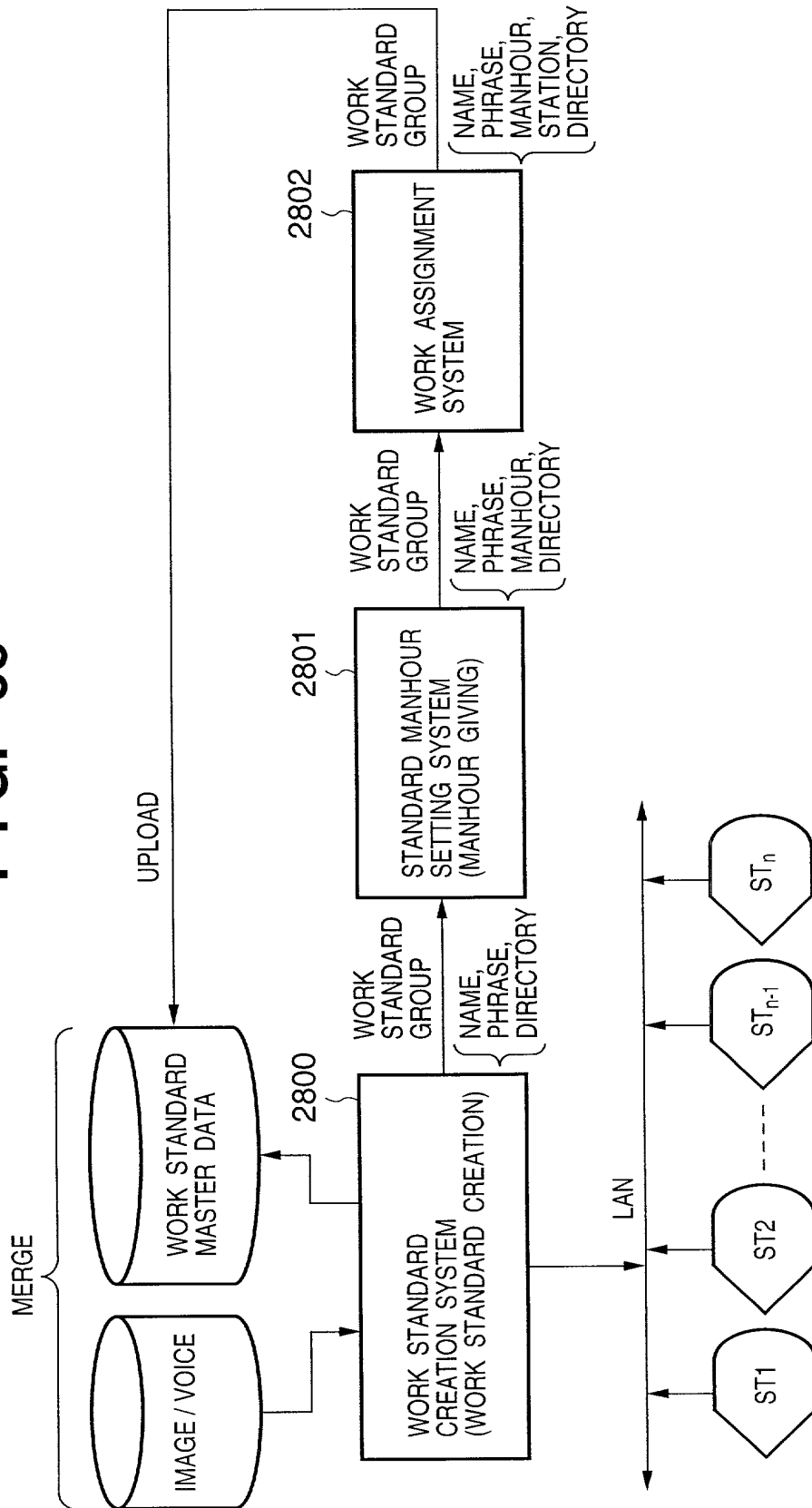


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

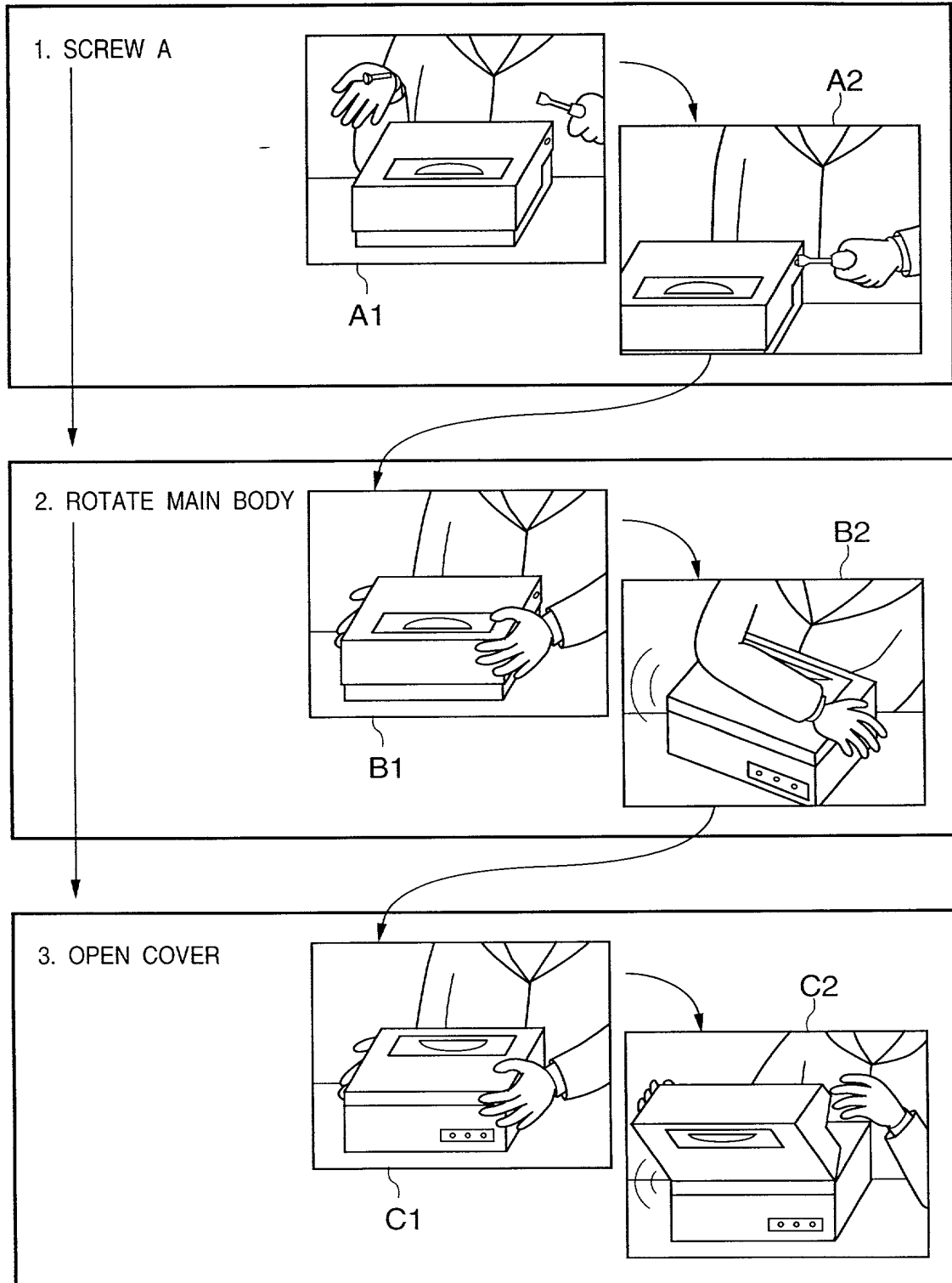


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

FIG. 92

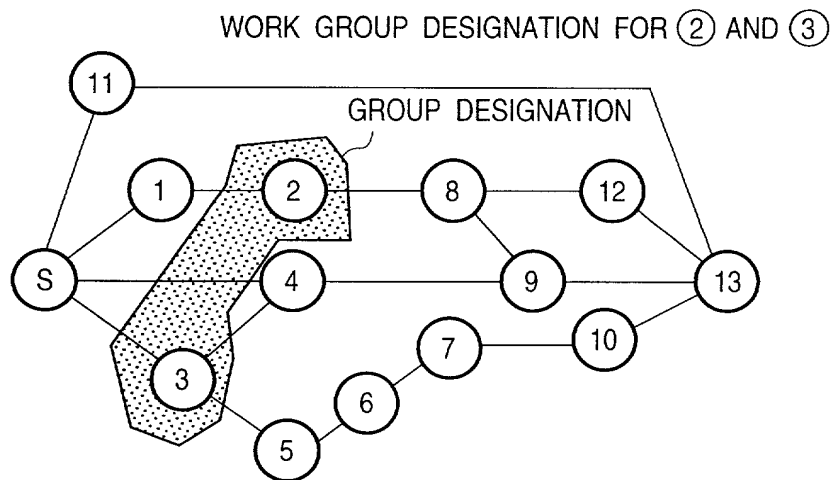


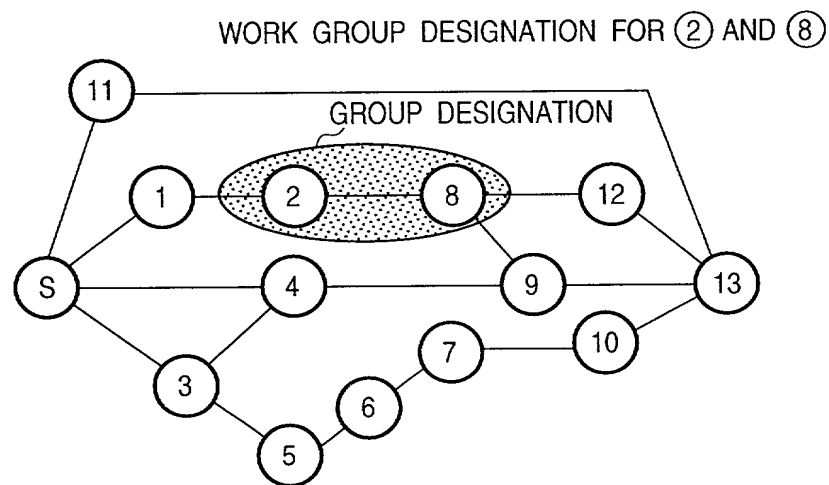
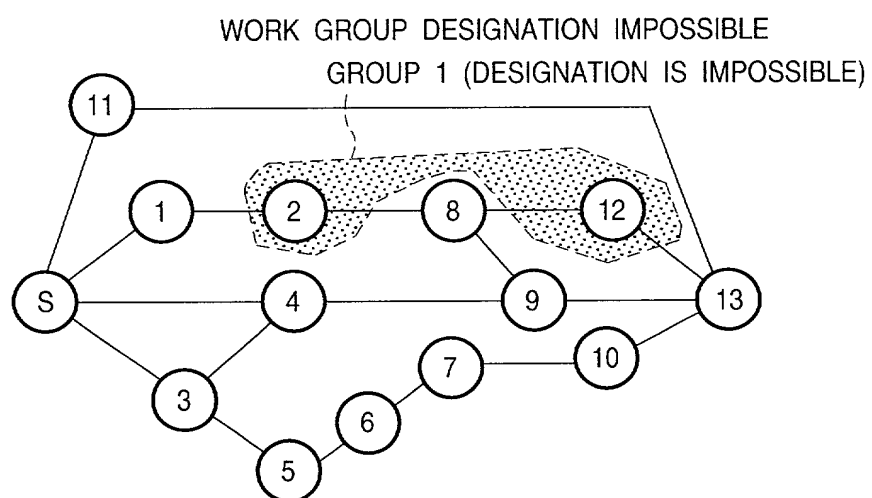
FIG. 93

FIG. 94

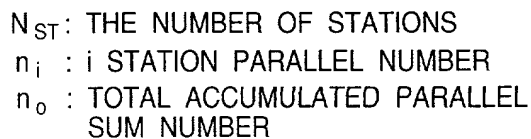
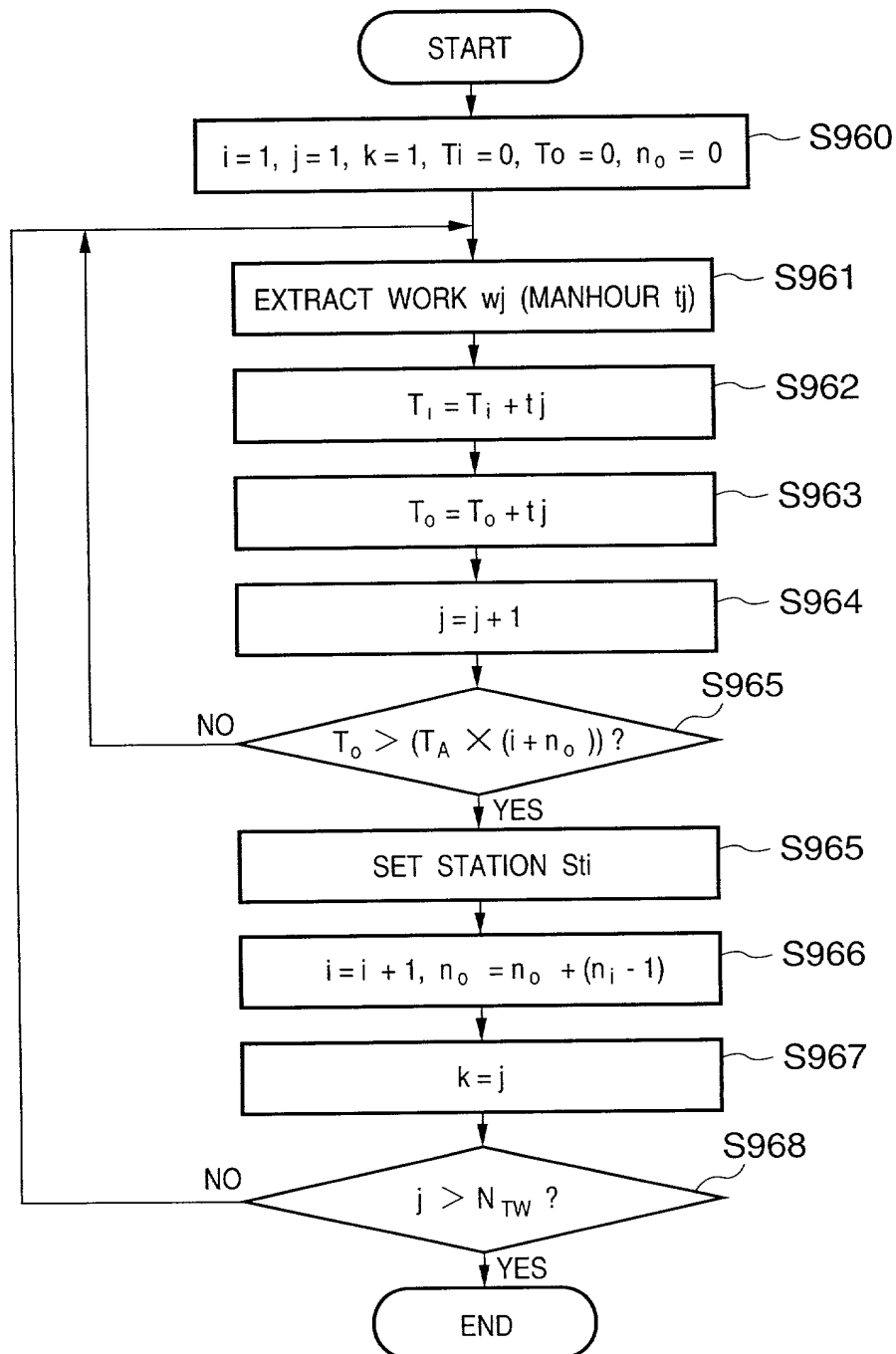


FIG. 96N_{ST}: THE NUMBER OF STATIONST_i : i STATION MANHOURT_A : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

T_o : TOTAL ACCUMULATED MANHOURn_i : i STATION PARALLEL NUMBERn_o : TOTAL ACCUMULATED PARALLEL
SUM NUMBER

FIG. 97

FILE(F) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

OPERATOR 2

OPERATOR 3

OPERATOR 4

OPERATOR 5

OPERATOR 6

S1

S2

S3

S4

S5

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
START	0	0	No
UNIT WORK NAME 1	34	10	No 01
UNIT WORK NAME 2	255	46	No 02
UNIT WORK NAME 6	92	26	No 06
UNIT WORK NAME 7	52	0	No 07
UNIT WORK NAME 8	52	0	No 08
UNIT WORK NAME 9	0	36	No 09
UNIT WORK NAME 10	71	48	No 10
UNIT WORK NAME 11	138	30	No 11
UNIT WORK NAME 12	97	20	No 12
UNIT WORK NAME 13	88	0	No 14
UNIT WORK NAME 14	46	18	No 15
UNIT WORK NAME 15	546	15	No 16
UNIT WORK NAME 17	58	20	No 17
UNIT WORK NAME 18	303	131	No 18
UNIT WORK NAME 19	84	26	No 19
UNIT WORK NAME 20	120	20	No 20
UNIT WORK NAME 21	310	66	No 21
UNIT WORK NAME 22	146	71	No 22
UNIT WORK NAME 23	106	26	No 23
UNIT WORK NAME 24	61	0	No 24
UNIT WORK NAME 25	51	10	No 25
END	0	0	No X

TOTAL 585 (RU)

TOTAL 1548 (RU) xxxxxx

TOTAL 572 (RU)

TOTAL 6238 (RU)

TOTAL 486 (RU)

PF 83.6%

PARALLEL STATIONS PF 117.3%

PF 96.7%

PF 95.2%

PF 73.6%

G STANDARD NO.

WORK NAME

WF

MEANS

MA-CHINE

PROVISIONAL MANHOUR

REMARKS

COMPOSITION EFFICIENCY %

96.43

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE : PRIORITY ORDER SCHEME